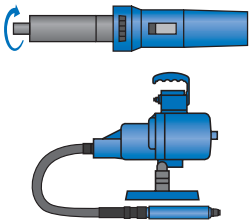
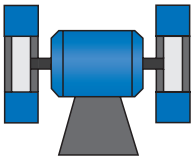

PFERD
Germany
www.pferd.com
200x32x51mm
8x1 1/4x2"
Grit 80
BW 20032-51 CN 80
CARBIDE

Mounted points
Table of contents

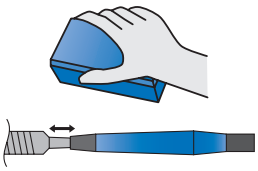
Mounted points



Bench grinding wheels



Grinding and polishing stones



Hand dressers

PFERD customer support

If you have any questions regarding the optimization of your grinding work or solutions to specific application problems, our sales representatives and technical advisers are happy to help.

Just get in touch! Our worldwide sales addresses can be found at: **www.pferd.com**

PFERDTOOL-CENTER

On the TOOL-CENTER, the point of sale from PFERD, you will find all the important information required for selecting the most appropriate tool.

Your local retailer or PFERD sales representative will be glad to answer any questions you might have.

PFERD packaging

Mounted points from PFERD are delivered in protective plastic pouches. The transparent front of the packaging enables you to immediately identify the shape, colour and grain of the tools. The European standard holes mean that all packs can be displayed on the **PFERD**TOOL-CENTER. CAST STEEL and CAST EDGE mounted points for foundries are delivered separately in robust industrial packaging (IP).

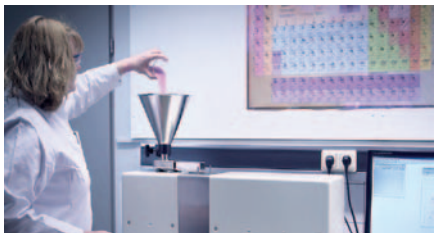
The packaging units (PU) for the individual tools are listed in the product tables. The packaging labels contain technical information, the description, the EAN code and the item number.

PFERD quality

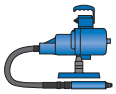
Mounted points, bench grinding wheels, hand dressers and grinding and polishing stones from PFERD are developed, manufactured and tested in accordance with stringent quality requirements.

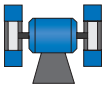
Research and development, our own machine and plant construction, and the continuous testing and further development of the quality and safety standards in our own laboratories all guarantee high PFERD quality.

PFERD quality management is certified according to ISO 9001.



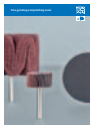
 Straight grinder

 Flexible shaft

 Bench grinder

 Manual filing tool

 Manual application



Detailed information and ordering data for Poliflex fine grinding points can be found in catalogue section 4.

Detailed information and ordering data for diamond grinding points can be found in catalogue section 5.

All tools and more information:
www.pferd.com

Mounted points
The fast way to the best tool

PFERD offers a very extensive range of ceramic-bonded and resinoid-bonded mounted points. Designed to meet individual grinding tool application needs, these products come in a broad range of grain types, grit sizes, hardness grades and shapes. The mounted points are manufactured on modern production lines to high standards of dimensional accuracy and stability, consistent quality and close tolerances. To select the correct mounted point, the material, main fields of application and specific operating requirements have to be taken into consideration.
This overview shows which types (abrasives and bonds) are suitable for the various materials and the tasks at hand.

❶ Material group
The various material groups are colour-coded and form the starting point for choosing the most appropriate mounted point.

❷ Application
After the material, the application must be selected. This differentiation is necessary in order to find the optimum mounted point and correct bond type. The mounted point bond, hardness and grain mixture have a decisive impact on the abrasive performance, tool life and aggressiveness of the tools:

❶ Material group			Bond ▶ ❸ Mounted point type ▶ Abrasive ▶ Recommended cutting speed ▶ ❷ Application ▼
Steel, cast steel	Steels up to 1,200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, tempering steels	**General use** on edge and surface **Surface grinding** with high stock removal rate **Edge grinding** with high dimensional stability
	Hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC)	Tool steels, tempering steels, alloyed steels	**General use** on edge and surface **Surface grinding** with high stock removal rate **Edge grinding** with high dimensional stability
	Cast steel	Non-alloyed cast steel, low-alloyed cast steel	**General use** on edge and surface **Surface grinding** with high stock removal rate **Edge grinding** with high dimensional stability
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	**Surface grinding** with high stock removal rate **Edge grinding** with high dimensional stability
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Aluminium alloys, brass, copper, zinc	**General use** on edge and surface
	Hard non-ferrous metals	Bronze, titanium, titanium alloys, hard aluminium alloys	
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)	
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite EN-GJL (GG), with nodular graphite/nodular cast iron EN-GJS (GGG), white annealed cast iron EN-GJMW (GTW), black cast iron EN-GJMB (GTS)	**Surface grinding** with high stock removal rate **Edge grinding and grinding out of metal contamination** with high dimensional stability
Plastics, other materials		Fibre-reinforced plastics, thermoplastics, rubber, wood	**General use** on edge and surface
			❹ Catalogue page ▶

- **General use:** For general use on surfaces and edges, the emphasis is on the balance between abrasive performance and tool life.
- **Surface grinding:** In surface grinding, the mounted points are subject to lower loads. The mounted point bond is therefore comparatively soft and has been designed to give high stock removal rates.
- **Edge grinding:** In edge grinding, the mounted points must be dimensionally stable. The mounted point bond is therefore comparatively hard and designed for a long tool life.

❸ Mounted point type
After determining the application (see column ❷), the type is selected in the horizontal row. The "highly suitable" types are indicated by a black dot (●). Further "suitable" types are indicated by an open dot (❍).

❹ Reference to catalogue page
Further information about the hardness grades, mounted point shapes and dimensions, as well as grit sizes, can be found on the corresponding catalogue pages stated in the table.

Resinoid bond		Vitrified bond							
INOX	INOX EDGE	RUBBER	ALU	TOUGH	CAST	CAST STEEL	STEEL	STEEL EDGE	CAST EDGE
ADW	AN	AH	CN	AWCO	ARN	ADR	ADW	AR	CU
									
35–50 m/s	35–50 m/s	5–20 m/s	20–40 m/s	30–50 m/s	30–50 m/s	25–40 m/s	30–50 m/s	25–40 m/s	30–50 m/s
							●		
❍							●	❍	
	❍						❍	●	
							●		
				●			❍		
				●				❍	
						●			
❍					❍	❍	●	❍	
	❍					❍	❍	●	
●	❍						❍		
❍	●							❍	
❍			●						
●			❍	●			❍		
❍				●					
❍	❍				●	❍		❍	❍
❍	❍				❍	❍		❍	●
		●	❍						
26	28	40	31	22	32	38	9	13	36

● = highly suitable ❍ = suitable

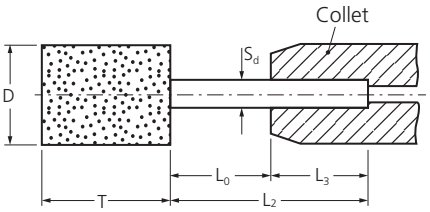
Mounted point dia. [mm]	Cutting speeds [m/s]						
	10	15	20	25	30	40	50
	Rotational speeds [RPM]						
2	95,500	143,200	191,000	238,700	286,500	382,000	477,500
3	63,700	95,500	127,300	159,200	191,000	254,600	318,300
4	47,700	71,600	95,500	119,400	143,200	191,000	238,700
5	38,200	57,300	76,400	95,500	114,600	152,800	191,000
6	31,800	47,700	63,700	79,600	95,500	127,300	159,200
7	27,300	40,900	54,600	68,200	81,900	109,100	136,400
8	23,900	35,800	47,700	59,700	71,600	95,500	119,400
10	19,100	28,600	38,200	47,700	57,300	76,400	95,500
12	15,900	23,900	31,800	39,800	47,700	63,700	79,600
14	13,600	20,500	27,300	34,100	40,900	54,600	68,200
16	11,900	17,900	23,900	29,800	35,800	47,700	59,700
20	9,500	14,300	19,100	23,900	28,600	38,200	47,700
25	7,600	11,500	15,300	19,100	22,900	30,600	38,200
32	6,000	9,000	11,900	14,900	17,900	23,900	29,800
40	4,800	7,200	9,500	11,900	14,300	19,100	23,900
50	3,800	5,700	7,600	9,500	11,500	15,300	19,100

Recommended rotational speed range

Refer to the table for the recommended rotational speed based on the diameter and cutting speed of your tool.
The recommended cutting speeds can be found in the introductory descriptions of the various hardness grades in this catalogue.

Note:
The optimum rotational speeds can be found in the product tables. These have been limited to 150,000 RPM, as conventional drives do not permit a higher rotational speed.

Example:
Mounted point dia. 20 mm
STEEL EDGE
Cutting speed: 30–50 m/s
Rotational speed: 28,600–47,700 RPM



Explanation of the code system according to EN 12413

D = Mounted point outer dia.
T = Mounted point width
S_d = Shank dia.

L_0 = Unsupported shank length
L_2 = Shank length
L_3 = Clamping length of shank

Safety notes

All PFERD mounted points are approved for a maximum operating speed of 50 m/s. The maximum permitted rotational speeds for the various shank lengths and shank diameters are defined in DIN 69170 based on EN 12413. These must be adhered to in order to avoid buckling of the shank during use. Regardless of the shank length, the clamping length (L_3) of the shank must be at least 10 mm.

The maximum permitted rotational speed calculated according to EN 12413 is determined by the following factors:
- Shape and dimensions of the mounted point
- Diameter of the steel shank S_d
- Unsupported shank length L_0

Each packaging unit of PFERD mounted points comes with rotational speed specifications for the unsupported shank length (L_0) of that mounted point. Proper concentric accuracy and correct clamping of the tool drive must also be ensured.

Tables with the maximum permitted rotational speeds for the entire PFERD mounted point product range are available on request.

 = Wear eye protection!

 = Wear hearing protection!

 = Wear a dust mask!

 = Wear gloves!

 = Read the safety notes!

Applications of mounted points

- Work on edges (chamfering, rounding)
- Deburring
- Grinding out
- Levelling
- Surface work
- Work on weld seams
- Finishing
- Grouting
- Roughening (RUBBER type)

ZY 2025 6 ADW 30 M 5 V STEEL
❶ ❷ ❸ ❹ ❺ ❻❼❽ ❾

❶ Shapes according to DIN 69170

ZY = Cylindrical
SP = Pointed tree
WR = Cylindrical with radius end
KU = Ball
KE = Conical with radius end
TO = Cup

US shapes according to ANSI B74.2
Series W (cylindrical mounted points in inch dimensions), series A and B (other shapes)

❷ Dimensions

The first digits of the description indicate the mounted point outer diameter D and mounted point width T in mm:
3 mm x 6 mm = 0306 **20 mm x 25 mm = 2025** 50 mm x 13 mm = 5013

US dimensions
Series W cylindrical mounted points and series A and B shaped mounted points are specified by a number (e.g. W 143).

❸ Shanks

Only the shank diameter is given in the description. The shank length is determined as follows:
Shank dia. 3 mm = 30 mm shank length
Shank dia. 6 mm = 40 mm shank length
Shank dia. 8 mm = 40 mm shank length
Shank dia. 1/8" = 1 1/4" shank length
Shank dia. 1/4" = 1 1/2" shank length

❹ Abrasives

In general, two grain types are used, with internationally defined descriptions according to ISO 525:
A = Aluminium oxide (Al_2O_3)
C = Silicon carbide (SiC)

The following abbreviations are used in order to specify the grain mixtures more precisely, beyond ISO 525:
AD = Aluminium oxide, dark red
AW = Aluminium oxide, white
AR = Aluminium oxide, pink
AN = Aluminium oxide, regular
AH = Bubble grain aluminium oxide
CN = Silicon carbide, green
CU = Silicon carbide, grey
CO = Ceramic oxide grain
ADW = Aluminium oxide mixture AD + AW
ARN = Aluminium oxide mixture AR + AN
ADR = Aluminium oxide mixture AD + AR
AWCO = Aluminium oxide mixture AW + CO

❺ Grit sizes according to ISO 525 and ISO 8486

The grit sizes used in PFERD mounted points are determined by the shape and diameter of the mounted point.
In this example, **grit size 30** is used.

❻ Hardness grades according to ISO 525

Hardness grades are classified using letters in alphabetical order to specify the hardness from soft to hard.
This example concerns a mounted point with **hardness M**.

Hardness grade coding				Property
A	B	C	D	Extremely soft
E	F	G	–	Very soft
H	I	J	K	Soft
L	**M**	N	O	**Medium**
P	Q	R	S	Hard
T	U	V	W	Very hard
X	Y	Z	–	Extremely hard

❼ Structure according to ISO 525

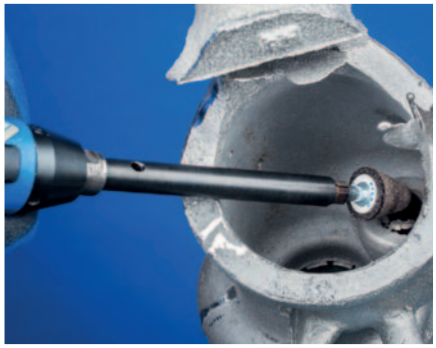
The internationally valid scale for structural density ranges from 1 = dense to 14 = open (porous) structure.
In this example, the structural density is specified by the number **5**.

❽ Bond according to ISO 525

Bond types are indicated with the following internationally standardized letters:
V = Vitrified bond
B = Resinoid bond

❾ Material-specific description

The material-specific description indicates the material to be processed.
STEEL = Universal for steel and cast steel
STEEL EDGE = Specialist for use on edges for steel and cast steel



Mounted points with a shank diameter of 3, 6 and 8 mm can be extended with drive spindle extensions. They allow access to hard-to-reach areas. The drive spindle extension is mounted in the collet of the tool drive (air grinder or electric grinder), or in the handpiece of the flexible shaft. In some applications, spindle extensions are an economical alternative to customized mounted points with long shanks.

Safety notes:

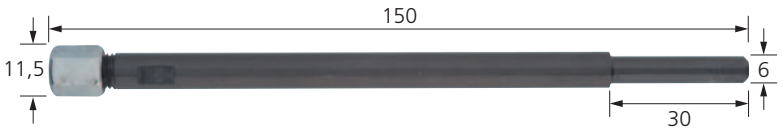
- For safety reasons, it is not possible to use drive spindle extensions in combination with mounted points that have long shanks.
- For additional safety notes, please refer to catalogue section 9.

More detailed information and ordering data for drive spindle extensions can be found in catalogue section 9.

= Read the safety notes!

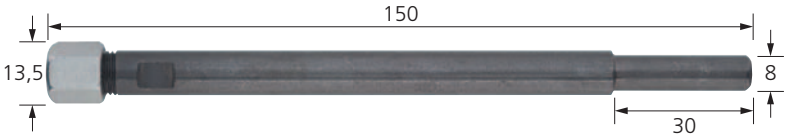
Extension SPV 150-3 S6 for shank diameter of 3 mm

EAN 4007220**185308**



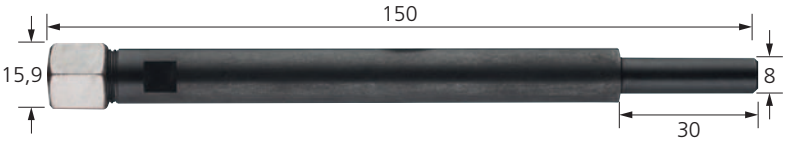
Extension SPV 150-6 S8 for shank diameter of 6 mm

EAN 4007220**185315**



Extension SPV 150-8 S8 for shank diameter of 8 mm

EAN 4007220**184400**



Extension SPV 100-6 S8 for shank diameter of 6 mm

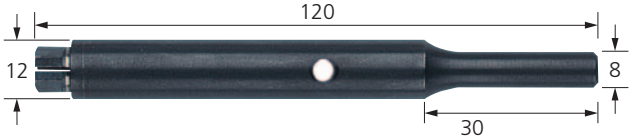
EAN 4007220**185261**

Extension SPV 100-6 SPG 6 for shank diameter of 6 mm

EAN 4007220**656051**

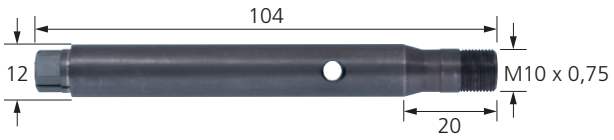
Extension SPV 75-6 S8 for shank diameter of 6 mm

EAN 4007220**185278**



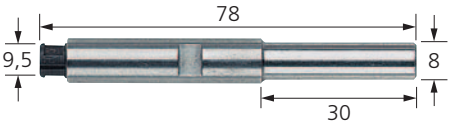
Extension SPV 75-6 SPG 6 for shank diameter of 6 mm

EAN 4007220**333143**



Extension SPV 50-3 S8 for shank diameter of 3 mm

EAN 4007220**185254**



STEEL mounted points

The STEEL type is the most universal bond for machining steel and cast steel. It is extremely well suited to grinding high-speed steel (HSS) moulded parts and weld dressing on steel constructions.

Advantages:

- Good grinding performance and stock removal rate in universal use on steel materials.
- Shortened grinding times and thus cost savings due to the high stock removal rate.
- Particularly suitable for work on surfaces and edges.

Materials that can be worked:

- Steel
- Cast steel

Type:

- Vitrified bond
- Aluminium oxide mixture of dark-red and white aluminium oxide

Recommendations for use:

- STEEL mounted points perform best at a cutting speed of 30 to 50 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Ordering notes:

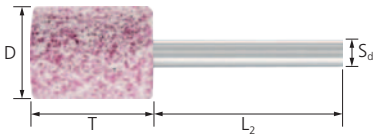
- Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.

STEEL, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.



D x T [mm]	Grit size 24	30	46	60	80	100	US shape	Opt. RPM	Max. RPM		Description
	EAN 4007220										
Shank dia. 3 x 30 mm [S_d x L_2]											
2 x 5	-	-	-	-	-	094365	W 141	150,000	201,800	10	ZY 0205 3 ADW ... M5V STEEL
3 x 6	-	-	-	-	-	094518	W 144	150,000	206,100	10	ZY 0306 3 ADW ... M5V STEEL
4 x 8	-	-	-	094679	-	094662	-	150,000	175,100	10	ZY 0408 3 ADW ... M5V STEEL
5 x 10	-	-	-	094877	-	094860	W 153	130,000	130,700	10	ZY 0510 3 ADW ... M5V STEEL
6 x 13	-	-	-	095140	-	095133	W 163	93,600	93,600	10	ZY 0613 3 ADW ... M5V STEEL
8 x 10	-	-	095331	-	095348	-	W 169	87,600	87,600	10	ZY 0810 3 ADW ... M5V STEEL
8 x 16	-	-	095522	-	659878	-	-	61,000	61,000	10	ZY 0816 3 ADW ... M5V STEEL
10 x 2	-	-	-	-	-	098653	W 172	85,000	95,400	10	ZY 1002 3 ADW ... M5V STEEL
10 x 13	-	-	095706	-	-	-	W 176	58,400	58,400	10	ZY 1013 3 ADW ... M5V STEEL
13 x 3	-	-	-	098783	-	098776	W 122	65,000	73,400	10	ZY 1303 3 ADW ... M5V STEEL
Shank dia. 6 x 40 mm [S_d x L_2]											
3 x 6	-	-	-	-	-	094457	W 144	150,000	206,100	10	ZY 0306 6 ADW ... M5V STEEL
4 x 8	-	-	-	094570	-	-	-	150,000	177,400	10	ZY 0408 6 ADW ... M5V STEEL
5 x 10	-	-	-	094754	-	-	W 153	130,000	157,800	10	ZY 0510 6 ADW ... M5V STEEL
6 x 13	-	-	-	095034	-	095027	W 163	131,500	131,500	10	ZY 0613 6 ADW ... M5V STEEL
8 x 10	-	-	-	-	095263	-	W 169	110,000	119,300	10	ZY 0810 6 ADW ... M5V STEEL
8 x 16	-	-	095416	-	095423	-	-	110,000	119,300	10	ZY 0816 6 ADW ... M5V STEEL
10 x 13	-	-	095614	-	095621	-	W 176	85,000	95,400	10	ZY 1013 6 ADW ... M5V STEEL
10 x 20	-	-	095850	-	095867	-	W 177	85,000	95,400	10	ZY 1020 6 ADW ... M5V STEEL
10 x 25	-	-	095959	-	659892	-	W 178	83,200	83,200	10	ZY 1025 6 ADW ... M5V STEEL
10 x 32	-	-	096017	-	659908	-	W 179	62,800	62,800	10	ZY 1032 6 ADW ... M5V STEEL
13 x 13	-	-	096093	-	-	-	W 185	65,000	73,400	10	ZY 1313 6 ADW ... M5V STEEL
13 x 20	-	-	096260	-	659915	-	W 186	65,000	73,400	10	ZY 1320 6 ADW ... M5V STEEL
13 x 25	-	-	096345	-	096352	-	W 187	65,000	66,000	10	ZY 1325 6 ADW ... M5V STEEL
13 x 40	-	-	098035	-	-	-	W 188	42,400	42,400	10	ZY 1340 6 ADW ... M5V STEEL
16 x 4	-	-	098912	-	660003	-	-	55,000	59,600	10	ZY 1604 6 ADW ... M5V STEEL

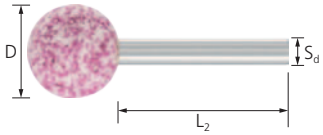
Continued on next page

Mounted points
For universal use on steel and cast steel

D x T [mm]	Grit size						US shape	Opt. RPM	Max. RPM		Description
	24	30	46	60	80	100					
	EAN 4007220										
16 x 20	-	096451	-	096468	-	-	W 195	55,000	59,600	10	ZY 1620 6 ADW ... M5V STEEL
16 x 32	-	096598	-	096604	-	-	-	51,200	51,200	10	ZY 1632 6 ADW ... M5V STEEL
16 x 40	-	096727	-	-	-	-	-	40,500	40,500	10	ZY 1640 6 ADW ... M5V STEEL
16 x 50	-	659922	-	-	-	-	W 197	31,300	31,300	10	ZY 1650 6 ADW ... M5V STEEL
20 x 6	-	-	099117	-	660010	-	W 201	43,000	47,700	10	ZY 2006 6 ADW ... M5V STEEL
20 x 20	-	096895	-	659946	-	-	W 204	43,000	47,700	10	ZY 2020 6 ADW ... M5V STEEL
20 x 25	-	096994	-	097007	-	-	W 205	43,000	47,700	10	ZY 2025 6 ADW ... M5V STEEL
20 x 32	-	097106	-	659953	-	-	W 206	41,100	41,100	10	ZY 2032 6 ADW ... M5V STEEL
20 x 40	-	097212	-	097229	-	-	W 207	32,400	32,400	10	ZY 2040 6 ADW ... M5V STEEL
25 x 6	-	-	099322	-	-	-	W 216	35,000	38,100	10	ZY 2506 6 ADW ... M5V STEEL
25 x 25	-	097335	-	659977	-	-	W 220	35,000	38,100	10	ZY 2525 6 ADW ... M5V STEEL
25 x 32	-	097434	-	-	-	-	-	32,900	32,900	10	ZY 2532 6 ADW ... M5V STEEL
32 x 8	-	099575	-	660034	-	-	W 226	27,000	29,800	5	ZY 3208 6 ADW ... M5V STEEL
32 x 16	099667	-	-	-	-	-	-	27,000	29,800	5	ZY 3216 6 ADW ... M5V STEEL
32 x 20	099773	-	660065	-	-	-	W 228	27,000	29,800	5	ZY 3220 6 ADW ... M5V STEEL
32 x 32	097595	-	097601	-	-	-	W 230	25,700	25,700	5	ZY 3232 6 ADW ... M5V STEEL
32 x 40	097717	-	659984	-	-	-	W 231	20,300	20,300	5	ZY 3240 6 ADW ... M5V STEEL
40 x 6	-	-	100455	-	-	-	W 235	22,000	23,800	5	ZY 4006 6 ADW ... M5V STEEL
40 x 10	-	099889	-	-	-	-	W 236	22,000	23,800	5	ZY 4010 6 ADW ... M5V STEEL
40 x 20	100028	-	100035	-	-	-	-	22,000	23,800	5	ZY 4020 6 ADW ... M5V STEEL
40 x 40	097809	-	659991	-	-	-	W 238	16,200	16,200	5	ZY 4040 6 ADW ... M5V STEEL
50 x 8	-	100509	-	-	-	-	-	17,000	19,000	5	ZY 5008 6 ADW ... M5V STEEL
50 x 13	-	100189	-	-	-	-	-	17,000	19,000	5	ZY 5013 6 ADW ... M5V STEEL
50 x 25	-	-	100325	-	-	-	W 242	17,000	19,000	5	ZY 5025 6 ADW ... M5V STEEL
Shank dia. 8 x 40 mm [S_d x L_2]											
50 x 25	100554	-	-	-	-	-	W 242	17,000	19,000	5	ZY 5025 8 ADW ... M5V STEEL

STEEL, ball type

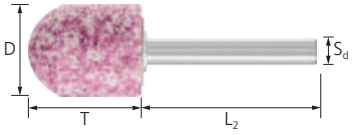
The ball shape KU is often used for contour grinding and backside deburring.



D [mm]	Grit size 24	30	46	60	Opt. RPM	Max. RPM		Description
	EAN 4007220							
Shank dia. 6 x 40 mm [S_d x L_2]								
13	-	-	101209	-	65,000	73,400	10	KU 13 6 ADW ... M5V STEEL
16	-	101261	-	660140	55,000	59,600	10	KU 16 6 ADW ... M5V STEEL
20	-	101339	-	101346	43,000	47,700	10	KU 20 6 ADW ... M5V STEEL
25	-	-	-	660164	35,000	38,100	10	KU 25 6 ADW ... M5V STEEL
32	660171	-	660188	-	27,000	29,800	5	KU 32 6 ADW ... M5V STEEL

STEEL, cylindrical with radius end type

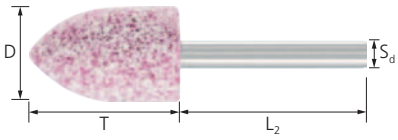
The cylindrical shape with radius end WR is suitable for a variety of deburring and grinding jobs.



D x T [mm]	Grit size 30	46	60	Opt. RPM	Max. RPM		Description
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
13 x 20	-	660096	-	65,000	73,400	10	WR 1320 6 ADW ... M5V STEEL
20 x 25	660119	-	660126	43,000	47,700	10	WR 2025 6 ADW ... M5V STEEL

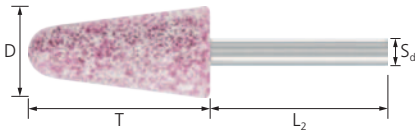
STEEL, pointed tree type

The pointed tree shape SP is suitable for machining small holes and bores.



D x T [mm]	Grit size 30	46	60	Opt. RPM	Max. RPM		Description
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
8 x 16	-	102008	-	110,000	119,300	10	SP 0816 6 ADW ... M5V STEEL
13 x 20	-	102138	-	65,000	73,400	10	SP 1320 6 ADW ... M5V STEEL
20 x 32	102237	-	660256	43,000	47,700	10	SP 2032 6 ADW ... M5V STEEL
20 x 50	102312	-	-	30,500	30,500	10	SP 2050 6 ADW ... M5V STEEL
25 x 40	660270	-	-	35,000	35,000	10	SP 2540 6 ADW ... M5V STEEL

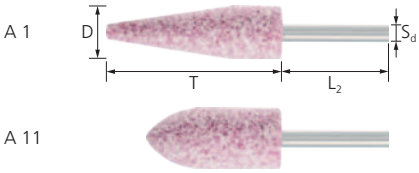
Mounted points
For universal use on steel and cast steel



STEEL, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.

D x T [mm]	Grit size 24	30	46	60	80	Opt. RPM	Max. RPM		Description
	EAN 4007220								
Shank dia. 6 x 40 mm [S_d x L_2]									
10 x 25	-	-	102763	-	102770	85,000	95,400	10	KE 1025 6 ADW ... M5V STEEL
16 x 45	-	-	102862	-	660300	52,000	52,000	10	KE 1645 6 ADW ... M5V STEEL
20 x 32	-	102671	-	660294	-	43,000	47,700	10	KE 2032 6 ADW ... M5V STEEL
20 x 40	-	102961	-	660348	-	43,000	47,700	10	KE 2040 6 ADW ... M5V STEEL
25 x 25	-	102534	-	-	-	35,000	38,100	10	KE 2525 6 ADW ... M5V STEEL
25 x 45	-	534687	-	660317	-	34,000	34,000	10	KE 2545 6 ADW ... M5V STEEL
25 x 70	-	103043	-	-	-	20,400	20,400	10	KE 2570 6 ADW ... M5V STEEL
32 x 32	660287	-	102596	-	-	27,000	29,800	5	KE 3232 6 ADW ... M5V STEEL



Series A STEEL

The shape A 1 is excellent for machining small holes and bores.
The shape A 11 is ideal for a variety of deburring and grinding jobs.

US shape	D x T [mm]	Grit size 30	Opt. RPM	Max. RPM		Description
		EAN 4007220				
Shank dia. 6.35 x 40 mm [S_d x L_2]						
A 1	19 x 64	114582	33,500	33,500	10	A 1 6,3 ADW 30 M5V STEEL
A 11	22 x 50	114681	30,400	30,400	10	A 11 6,3 ADW 30 M5V STEEL

Mounted point set SSO 5300 STEEL

Contains 100 STEEL type mounted points with shank diameter 6 mm in the most common shapes and dimensions for the most common applications.

Delivered in sales-promoting display box for the point of sale in shops.

Contents:
10 pieces each of:

- ZY 1620
- ZY 2025
- ZY 2506
- ZY 2532
- ZY 3216
- ZY 3232
- ZY 4020
- SP 2032
- KE 2032
- KE 2570

S_d [mm]	Grit size coarse		Description
	EAN 4007220		
6	114513	1	SSO 5300 STEEL

STEEL EDGE mounted points

The STEEL EDGE type is particularly well suited to edge grinding and deburring work on steel and cast steel components. Its applications also include grinding of chamfers in preparation for weld seams and grinding of contours.

Advantages:

- Long tool life and low tool wear due to hard, dimensionally stable bond.
- Economical to use due to the high edge stability even on low-speed tool drives.
- Particularly well suited to work on edges.

Materials that can be worked:

- Steel
- Cast steel

Type:

- Vitrified bond
- Pink aluminium oxide

Recommendations for use:

- STEEL EDGE mounted points perform best at a cutting speed of 25 to 40 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

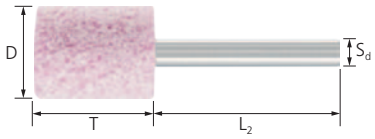
Ordering notes:

- Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.

Mounted points
For edge grinding on steel and cast steel



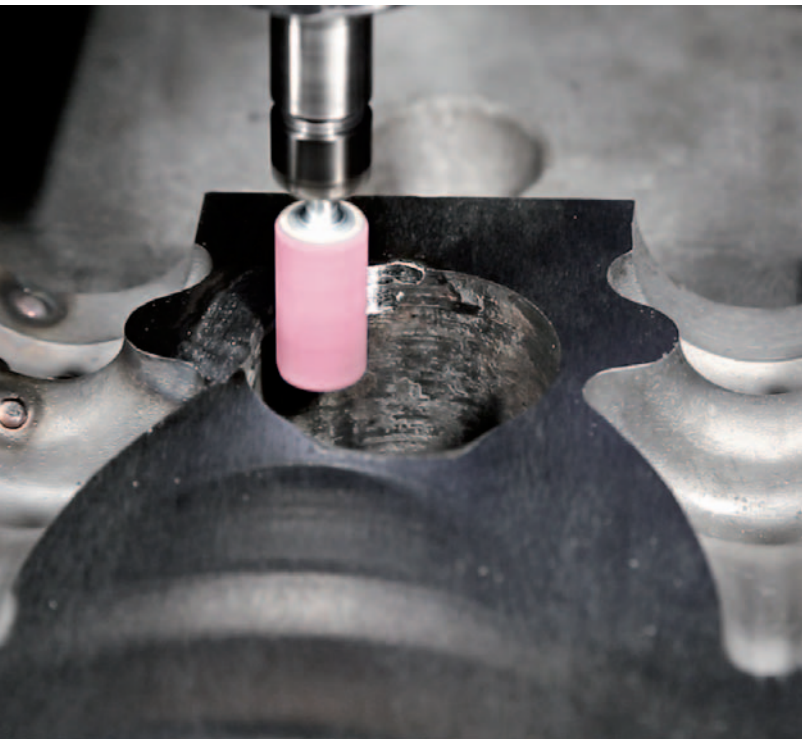
STEEL EDGE, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

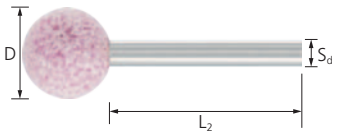
D x T [mm]	Grit size						US shape	Opt. RPM	Max. RPM		Description
	24	30	46	60	80	100					
	EAN 4007220										
Shank dia. 3 x 30 mm [S_d x L_2]											
2 x 5	-	-	-	-	-	094372	W 141	150,000	201,800	10	ZY 0205 3 AR ... O5V STEEL EDGE
3 x 6	-	-	-	-	-	094525	W 144	150,000	206,100	10	ZY 0306 3 AR ... O5V STEEL EDGE
3 x 10	-	-	-	-	-	118139	W 145	131,400	131,400	10	ZY 0310 3 AR ... O5V STEEL EDGE
3 x 13	-	-	-	-	-	118146	W 146	95,400	95,400	10	ZY 0313 3 AR ... O5V STEEL EDGE
4 x 8	-	-	-	094693	-	094686	-	150,000	175,100	10	ZY 0408 3 AR ... O5V STEEL EDGE
5 x 10	-	-	-	094891	-	094884	W 153	130,000	130,700	10	ZY 0510 3 AR ... O5V STEEL EDGE
5 x 13	-	-	-	-	-	118238	W 154	114,800	114,800	10	ZY 0513 3 AR ... O5V STEEL EDGE
5 x 15	-	-	-	534670	-	-	-	98,100	98,100	10	ZY 0515 3 AR ... O5V STEEL EDGE
6 x 10	-	-	-	118320	-	118313	W 162	100,000	110,500	10	ZY 0610 3 AR ... O5V STEEL EDGE
6 x 13	-	-	-	095164	-	095157	W 163	93,600	93,600	10	ZY 0613 3 AR ... O5V STEEL EDGE
6 x 19	-	-	-	118368	-	118351	W 164	64,500	64,500	10	ZY 0619 3 AR ... O5V STEEL EDGE
6 x 25	-	-	-	534656	-	-	-	53,100	53,100	10	ZY 0625 3 AR ... O5V STEEL EDGE
8 x 2	-	-	-	-	-	098578	W 165	85,000	119,300	10	ZY 0802 3 AR ... O5V STEEL EDGE
8 x 10	-	-	095355	-	095362	-	W 169	85,000	87,600	10	ZY 0810 3 AR ... O5V STEEL EDGE
8 x 13	-	-	118399	-	118405	-	W 170	74,400	74,400	10	ZY 0813 3 AR ... O5V STEEL EDGE
8 x 16	-	-	095546	-	095553	-	-	61,000	61,000	10	ZY 0816 3 AR ... O5V STEEL EDGE
10 x 2	-	-	-	-	-	098660	W 172	65,000	95,400	10	ZY 1002 3 AR ... O5V STEEL EDGE
10 x 3	-	-	-	118429	-	-	W 173	65,000	100,500	10	ZY 1003 3 AR ... O5V STEEL EDGE
10 x 10	-	-	-	-	118467	-	W 175	65,000	77,500	10	ZY 1010 3 AR ... O5V STEEL EDGE
10 x 13	-	-	095720	-	095737	-	W 176	58,400	58,400	10	ZY 1013 3 AR ... O5V STEEL EDGE
13 x 3	-	-	-	098806	-	098790	W 182	50,000	73,400	10	ZY 1303 3 AR ... O5V STEEL EDGE
13 x 13	-	-	096154	-	096161	-	W 185	45,300	45,300	10	ZY 1313 3 AR ... O5V STEEL EDGE
16 x 3	-	-	-	118580	-	-	W 191	42,000	60,000	10	ZY 1603 3 AR ... O5V STEEL EDGE
16 x 4	-	-	098974	-	098981	-	-	42,000	59,600	10	ZY 1604 3 AR ... O5V STEEL EDGE
19 x 3	-	-	-	118627	-	-	W 200	35,000	49,900	10	ZY 1903 3 AR ... O5V STEEL EDGE
20 x 6	-	-	-	-	100424	-	W 201	33,000	47,700	10	ZY 2006 3 AR ... O5V STEEL EDGE
25 x 3	-	-	-	-	-	118696	W 215	26,000	37,500	10	ZY 2503 3 AR ... O5V STEEL EDGE
Shank dia. 6 x 40 mm [S_d x L_2]											
3 x 6	-	-	-	-	-	094464	W 144	150,000	206,100	10	ZY 0306 6 AR ... O5V STEEL EDGE
4 x 8	-	-	-	094594	-	094587	-	150,000	177,400	10	ZY 0408 6 AR ... O5V STEEL EDGE
5 x 10	-	-	-	094778	-	094761	W 153	130,000	157,800	10	ZY 0510 6 AR ... O5V STEEL EDGE
6 x 13	-	-	-	095058	-	095041	W 163	100,000	131,500	10	ZY 0613 6 AR ... O5V STEEL EDGE
6 x 25	-	-	-	534663	-	-	-	62,200	62,200	10	ZY 0625 6 AR ... O5V STEEL EDGE
8 x 10	-	-	095270	-	095287	-	W 169	85,000	119,300	10	ZY 0810 6 AR ... O5V STEEL EDGE
8 x 16	-	-	095430	-	095447	-	-	85,000	119,300	10	ZY 0816 6 AR ... O5V STEEL EDGE
10 x 13	-	-	095638	-	095645	-	W 176	65,000	95,400	10	ZY 1013 6 AR ... O5V STEEL EDGE
10 x 20	-	-	095874	-	095881	-	W 177	65,000	95,400	10	ZY 1020 6 AR ... O5V STEEL EDGE
10 x 25	-	-	095966	-	095973	-	W 178	65,000	83,200	10	ZY 1025 6 AR ... O5V STEEL EDGE
10 x 32	-	-	096024	-	096031	-	W 179	62,800	62,800	10	ZY 1032 6 AR ... O5V STEEL EDGE
13 x 3	-	-	-	098745	-	-	W 182	50,000	73,400	10	ZY 1303 6 AR ... O5V STEEL EDGE
13 x 13	-	-	096109	-	096116	-	W 185	50,000	73,400	10	ZY 1313 6 AR ... O5V STEEL EDGE
13 x 20	-	-	096277	-	096284	-	W 186	50,000	73,400	10	ZY 1320 6 AR ... O5V STEEL EDGE
13 x 25	-	-	096369	-	096376	-	W 187	50,000	66,000	10	ZY 1325 6 AR ... O5V STEEL EDGE
13 x 40	-	-	098059	-	-	-	W 188	42,400	42,400	10	ZY 1340 6 AR ... O5V STEEL EDGE
16 x 4	-	-	098929	-	098936	-	-	42,000	59,600	10	ZY 1604 6 AR ... O5V STEEL EDGE
16 x 10	-	099063	-	-	-	-	W 193	42,000	59,600	10	ZY 1610 6 AR ... O5V STEEL EDGE
16 x 20	-	096475	-	096482	-	-	W 195	42,000	59,600	10	ZY 1620 6 AR ... O5V STEEL EDGE
16 x 32	-	096611	-	096628	-	-	-	42,000	51,200	10	ZY 1632 6 AR ... O5V STEEL EDGE
16 x 40	-	096741	-	096758	-	-	-	40,500	40,500	10	ZY 1640 6 AR ... O5V STEEL EDGE

Continued on next page

D x T [mm]	Grit size						US shape	Opt. RPM	Max. RPM		Description
	24	30	46	60	80	100					
	EAN 4007220										
16 x 50	-	096840	-	-	-	-	W 197	31,300	31,300	10	ZY 1650 6 AR ... O5V STEEL EDGE
20 x 6	-	-	099124	-	099131	-	W 201	33,000	47,700	10	ZY 2006 6 AR ... O5V STEEL EDGE
20 x 10	-	099216	-	099223	-	-	W 202	33,000	47,700	10	ZY 2010 6 AR ... O5V STEEL EDGE
20 x 20	-	096901	-	096918	-	-	W 204	33,000	47,700	10	ZY 2020 6 AR ... O5V STEEL EDGE
20 x 25	-	097014	-	097021	-	-	W 205	33,000	47,700	10	ZY 2025 6 AR ... O5V STEEL EDGE
20 x 32	-	097113	-	097120	-	-	W 206	33,000	41,100	10	ZY 2032 6 AR ... O5V STEEL EDGE
20 x 40	-	097236	-	097243	-	-	W 207	32,400	32,400	10	ZY 2040 6 AR ... O5V STEEL EDGE
20 x 50	-	098080	-	-	-	-	W 208	25,100	25,100	10	ZY 2050 6 AR ... O5V STEEL EDGE
25 x 6	-	-	099339	-	099346	-	W 214	26,000	38,100	10	ZY 2506 6 AR ... O5V STEEL EDGE
25 x 10	-	099377	-	-	-	-	W 217	26,000	38,100	10	ZY 2510 6 AR ... O5V STEEL EDGE
25 x 13	-	099438	-	-	-	-	W 218	26,000	38,100	10	ZY 2513 6 AR ... O5V STEEL EDGE
25 x 16	-	-	-	099513	-	-	-	26,000	38,100	10	ZY 2516 6 AR ... O5V STEEL EDGE
25 x 25	-	097342	-	097359	-	-	W 220	26,000	38,100	10	ZY 2525 6 AR ... O5V STEEL EDGE
25 x 32	-	097458	-	097465	-	-	-	26,000	32,900	10	ZY 2532 6 AR ... O5V STEEL EDGE
25 x 40	-	098127	-	-	-	-	W 221	26,000	26,000	10	ZY 2540 6 AR ... O5V STEEL EDGE
32 x 6	-	-	119112	-	-	-	W 225	21,000	30,000	5	ZY 3206 6 AR ... O5V STEEL EDGE
32 x 8	-	099582	-	099599	-	-	-	21,000	29,800	5	ZY 3208 6 AR ... O5V STEEL EDGE
32 x 20	099780	-	099797	-	-	-	W 228	21,000	29,800	5	ZY 3220 6 AR ... O5V STEEL EDGE
32 x 32	097618	-	097625	-	-	-	W 230	21,000	25,700	5	ZY 3232 6 AR ... O5V STEEL EDGE
32 x 40	097731	-	097748	-	-	-	W 231	20,300	20,300	5	ZY 3240 6 AR ... O5V STEEL EDGE
40 x 6	-	-	100462	-	-	-	W 235	16,000	23,800	5	ZY 4006 6 AR ... O5V STEEL EDGE
40 x 10	-	099896	-	099902	-	-	W 236	16,000	23,800	5	ZY 4010 6 AR ... O5V STEEL EDGE
40 x 15	-	099957	-	099964	-	-	-	16,000	23,800	5	ZY 4015 6 AR ... O5V STEEL EDGE
40 x 20	100042	-	100059	-	-	-	-	16,000	23,800	5	ZY 4020 6 AR ... O5V STEEL EDGE
40 x 40	097816	-	097823	-	-	-	W 238	16,000	16,200	5	ZY 4040 6 AR ... O5V STEEL EDGE
50 x 8	-	100516	-	-	-	-	-	13,000	19,000	5	ZY 5008 6 AR ... O5V STEEL EDGE
50 x 13	-	100202	-	-	-	-	-	13,000	19,000	5	ZY 5013 6 AR ... O5V STEEL EDGE
50 x 25	100332	-	100349	-	-	-	W 242	13,000	19,000	5	ZY 5025 6 AR ... O5V STEEL EDGE
Shank dia. 8 x 40 mm [S_d x L_2]											
32 x 40	098196	-	-	-	-	-	W 231	21,000	29,800	5	ZY 3240 8 AR ... O5V STEEL EDGE
40 x 40	098271	-	-	-	-	-	W 238	16,000	23,800	5	ZY 4040 8 AR ... O5V STEEL EDGE



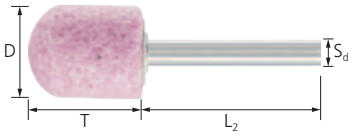
Mounted points
For edge grinding on steel and cast steel



STEEL EDGE, ball type

The ball shape KU is often used for contour grinding and backside deburring.

D [mm]	Grit size						Opt. RPM	Max. RPM		Description
	24	30	46	60	80	100				
	EAN 4007220									
Shank dia. 3 x 30 mm [S_d x L_2]										
3	-	-	-	-	-	101018	150,000	300,200	10	KU 03 3 AR ... O5V STEEL EDGE
5	-	-	-	101100	-	101094	130,000	190,900	10	KU 05 3 AR ... O5V STEEL EDGE
8	-	-	101551	-	101568	-	85,000	116,200	10	KU 08 3 AR ... O5V STEEL EDGE
10	-	-	101520	-	101537	-	65,000	83,300	10	KU 10 3 AR ... O5V STEEL EDGE
13	-	-	101605	-	101612	-	50,000	54,000	10	KU 13 3 AR ... O5V STEEL EDGE
Shank dia. 6 x 40 mm [S_d x L_2]										
3	-	-	-	-	-	100981	150,000	317,300	10	KU 03 6 AR ... O5V STEEL EDGE
5	-	-	-	101056	-	101049	130,000	190,900	10	KU 05 6 AR ... O5V STEEL EDGE
8	-	-	101148	-	101155	-	85,000	119,300	10	KU 08 6 AR ... O5V STEEL EDGE
10	-	-	101490	-	101506	-	65,000	95,400	10	KU 10 6 AR ... O5V STEEL EDGE
13	-	-	101216	-	101223	-	50,000	73,400	10	KU 13 6 AR ... O5V STEEL EDGE
16	-	101278	-	101285	-	-	42,000	59,600	10	KU 16 6 AR ... O5V STEEL EDGE
20	-	101353	-	101360	-	-	33,000	47,700	10	KU 20 6 AR ... O5V STEEL EDGE
25	-	101391	-	101407	-	-	26,000	38,100	10	KU 25 6 AR ... O5V STEEL EDGE
32	101445	-	101452	-	-	-	21,000	29,800	5	KU 32 6 AR ... O5V STEEL EDGE



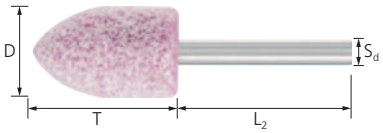
STEEL EDGE, cylindrical with radius end type

The cylindrical shape with radius end WR is suitable for a variety of deburring and grinding jobs.

D x T [mm]	Grit size					Opt. RPM	Max. RPM		Description
	30	46	60	80	100				
	EAN 4007220								
Shank dia. 3 x 30 mm [S_d x L_2]									
3 x 6	-	-	-	-	100745	150,000	219,800	10	WR 0306 3 AR ... O5V STEEL EDGE
5 x 10	-	-	100837	-	100820	130,000	136,500	10	WR 0510 3 AR ... O5V STEEL EDGE
Shank dia. 6 x 40 mm [S_d x L_2]									
5 x 10	-	-	100783	-	-	130,000	168,400	10	WR 0510 6 AR ... O5V STEEL EDGE
8 x 16	-	100851	-	100868	-	85,000	119,300	10	WR 0816 6 AR ... O5V STEEL EDGE
13 x 20	-	100905	-	100912	-	50,000	73,400	10	WR 1320 6 AR ... O5V STEEL EDGE
20 x 25	100943	-	100950	-	-	33,000	47,700	10	WR 2025 6 AR ... O5V STEEL EDGE

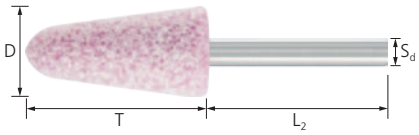
STEEL EDGE, pointed tree type

The pointed tree shape SP is excellent for machining small holes and bores.



D x T [mm]	Grit size					Opt. RPM	Max. RPM		Description
	30	46	60	80	100				
	EAN 4007220								
Shank dia. 3 x 30 mm [S_d x L_2]									
3 x 6	-	-	-	-	101810	150,000	252,000	10	SP 0306 3 AR ... O5V STEEL EDGE
5 x 10	-	-	101940	-	101933	130,000	149,500	10	SP 0510 3 AR ... O5V STEEL EDGE
8 x 16	-	102084	-	102091	-	72,800	72,800	10	SP 0816 3 AR ... O5V STEEL EDGE
Shank dia. 6 x 40 mm [S_d x L_2]									
3 x 6	-	-	-	-	101773	150,000	255,500	10	SP 0306 6 AR ... O5V STEEL EDGE
5 x 10	-	-	101872	-	101865	130,000	190,900	10	SP 0510 6 AR ... O5V STEEL EDGE
8 x 16	-	102015	-	102022	-	85,000	119,300	10	SP 0816 6 AR ... O5V STEEL EDGE
13 x 20	-	102152	-	102169	-	50,000	73,400	10	SP 1320 6 AR ... O5V STEEL EDGE
20 x 32	102244	-	102251	-	-	33,000	47,700	10	SP 2032 6 AR ... O5V STEEL EDGE
20 x 50	102329	-	-	-	-	30,500	30,500	10	SP 2050 6 AR ... O5V STEEL EDGE
25 x 40	102350	-	-	-	-	26,000	35,000	10	SP 2540 6 AR ... O5V STEEL EDGE

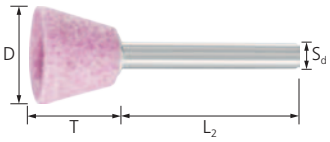
Mounted points
For edge grinding on steel and cast steel



STEEL EDGE, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position when smoothing out a ridge on a surface.

D x T [mm]	Grit size					Opt. RPM	Max. RPM		Description
	24	30	46	60	80				
	EAN 4007220								
Shank dia. 3 x 30 mm [S_d x L_2]									
10 x 10	-	-	102404	-	-	65,000	95,400	10	KE 1010 3 AR ... O5V STEEL EDGE
Shank dia. 6 x 40 mm [S_d x L_2]									
10 x 10	-	-	102374	-	-	65,000	95,400	10	KE 1010 6 AR ... O5V STEEL EDGE
10 x 25	-	-	102787	-	102794	65,000	95,400	10	KE 1025 6 AR ... O5V STEEL EDGE
13 x 13	-	-	102428	-	-	50,000	73,400	10	KE 1313 6 AR ... O5V STEEL EDGE
16 x 16	-	102466	-	102473	-	42,000	59,600	10	KE 1616 6 AR ... O5V STEEL EDGE
16 x 45	-	-	102879	-	102886	42,000	52,000	10	KE 1645 6 AR ... O5V STEEL EDGE
20 x 20	-	102497	-	102503	-	33,000	47,700	10	KE 2020 6 AR ... O5V STEEL EDGE
20 x 32	-	102688	-	102695	-	33,000	47,700	10	KE 2032 6 AR ... O5V STEEL EDGE
20 x 40	-	102978	-	102985	-	33,000	47,700	10	KE 2040 6 AR ... O5V STEEL EDGE
25 x 25	-	102541	-	102558	-	26,000	38,100	10	KE 2525 6 AR ... O5V STEEL EDGE
25 x 45	-	102923	-	102930	-	26,000	34,000	10	KE 2545 6 AR ... O5V STEEL EDGE
25 x 70	-	103067	-	-	-	20,400	20,400	10	KE 2570 6 AR ... O5V STEEL EDGE
32 x 32	102602	-	102619	-	-	21,000	29,800	5	KE 3232 6 AR ... O5V STEEL EDGE
Shank dia. 8 x 40 mm [S_d x L_2]									
32 x 50	103098	-	-	-	-	21,000	29,800	5	KE 3250 8 AR ... O5V STEEL EDGE



STEEL EDGE, cup type

The cup shape TO is ideal for work on profiles, planar surfaces and ledges, without the cylindrical surface being damaged.

D x T [mm]	Grit size				Opt. RPM	Max. RPM		Description
	24	30	46	60				
	EAN 4007220							
Shank dia. 6 x 40 mm [S_d x L_2]								
20 x 16	-	103128	-	103135	33,000	47,700	10	TO 2016 6 AR ... O5V STEEL EDGE
25 x 20	-	103142	-	-	26,000	38,100	10	TO 2520 6 AR ... O5V STEEL EDGE
32 x 25	103173	-	103180	-	21,000	29,800	5	TO 3225 6 AR ... O5V STEEL EDGE

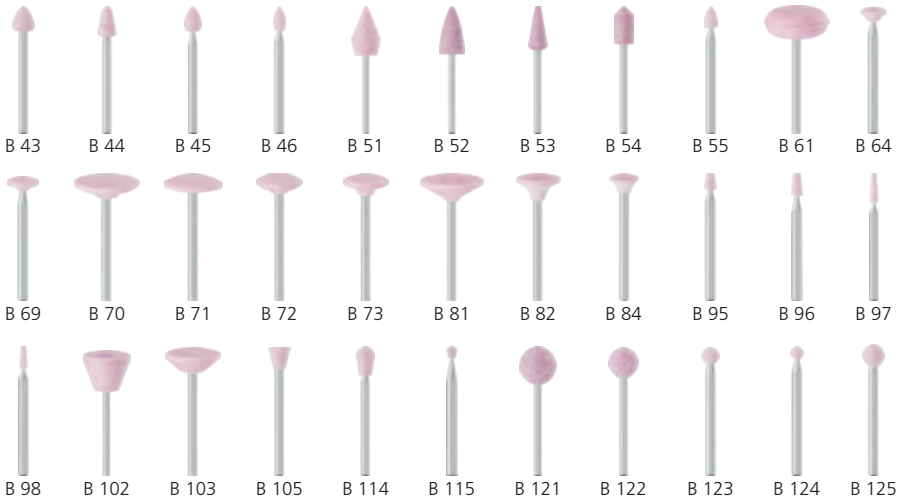
Series A STEEL EDGE

Series A mounted points are generally used on larger components. Due to the special shapes of series A mounted points, it is possible to grind in a variety of contours.
The applications range from grinding out slits and grooves in hard-to-reach areas to machining bores and small holes as well as smoothing.

Explanation of the code system:
D = Mounted point outer dia.
T = Mounted point width
S_d = Shank dia.
L_2 = Shank length

US shape	D x T [mm]	Grit size 30	Grit size 60	Grit size 100	Opt. RPM	Max. RPM		Description
		EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]								
A 1	19 x 64	117101	-	-	30,400	30,400	10	A 6 AR 30 O5V STEEL EDGE
A 2	25 x 32	117125	-	-	26,000	37,500	10	A 2 6 AR 30 O5V STEEL EDGE
A 3	25 x 70	117149	-	-	18,600	18,600	10	A 3 6 AR 30 O5V STEEL EDGE
A 4	32 x 32	117163	-	-	21,000	30,000	5	A 4 6 AR 30 O5V STEEL EDGE
A 5	19 x 29	117170	-	-	35,000	49,900	10	A 5 6 AR 30 O5V STEEL EDGE
A 6	19 x 29	117187	-	-	35,000	49,900	10	A 6 6 AR 30 O5V STEEL EDGE
A 11	22 x 50	117200	-	-	27,600	27,600	10	A 11 6 AR 30 O5V STEEL EDGE
A 12	17 x 32	117224	-	-	40,000	54,500	10	A 12 6 AR 30 O5V STEEL EDGE
A 14	17 x 22	117248	-	-	40,000	54,500	10	A 14 6 AR 30 O5V STEEL EDGE
A 15	6 x 27	-	117262	117255	100,000	112,900	10	A 15 6 AR ... O5V STEEL EDGE
A 21	25 x 25	117279	-	-	26,000	37,500	10	A 21 6 AR 30 O5V STEEL EDGE
A 24	6 x 19	-	117316	117309	100,000	117,400	10	A 24 6 AR ... O5V STEEL EDGE
A 25	25	117323	-	-	26,000	37,500	10	A 25 6 AR 30 O5V STEEL EDGE
A 26	16	117330	-	-	42,000	60,000	10	A 26 6 AR 30 O5V STEEL EDGE
A 34	38 x 10	117385	-	-	18,000	25,000	5	A 34 6 AR 30 O5V STEEL EDGE
A 36	41 x 10	-	117415	-	16,000	23,100	5	A 36 6 AR 60 O5V STEEL EDGE
A 37	32 x 6	-	117422	-	21,000	30,000	5	A 37 6 AR 60 O5V STEEL EDGE
Shank dia. 6.35 x 40 mm [S_d x L_2]								
A 1	19 x 64	114599	-	-	33,500	33,500	10	A 1 6,3 AR 30 O5V STEEL EDGE
A 2	25 x 32	114612	-	-	26,000	37,500	10	A 2 6,3 AR 30 O5V STEEL EDGE
A 3	25 x 70	114636	-	-	18,600	18,600	10	A 3 6,3 AR 30 O5V STEEL EDGE
A 4	32 x 32	114650	-	-	21,000	30,000	5	A 4 6,3 AR 30 O5V STEEL EDGE
A 5	19 x 29	114667	-	-	35,000	49,900	10	A 5 6,3 AR 30 O5V STEEL EDGE
A 11	22 x 50	114698	-	-	30,400	30,400	10	A 11 6,3 AR 30 O5V STEEL EDGE
A 12	17 x 32	114711	-	-	40,000	54,500	10	A 12 6,3 AR 30 O5V STEEL EDGE
A 15	6 x 27	-	114759	-	100,000	112,900	10	A 15 6,3 AR 60 O5V STEEL EDGE
A 24	6 x 19	-	114803	-	100,000	117,400	10	A 24 6,3 AR 60 O5V STEEL EDGE
A 25	25	114810	-	-	26,000	37,500	10	A 25 6,3 AR 30 O5V STEEL EDGE
A 36	41 x 10	-	114902	-	16,000	23,100	5	A 36 6,3 AR 60 O5V STEEL EDGE
A 37	32 x 6	-	114919	-	21,000	30,000	5	A 37 6,3 AR 60 O5V STEEL EDGE

Mounted points
For edge grinding on steel and cast steel



Series B STEEL EDGE

Series B mounted points are generally used on smaller or more delicate components, such as in tool and mould construction. Due to the special shapes of series B mounted points, it is possible to grind in a variety of contours. The applications range from grinding out slits and grooves in hard-to-reach areas to machining bores and small holes as well as smoothing.

Explanation of the code system:

D = Mounted point outer dia.
T = Mounted point width
S_d = Shank dia.
L_2 = Shank length

US shape	D x T [mm]	Grit size				Opt. RPM	Max. RPM		Description
		46	60	80	100				
		EAN 4007220							
Shank dia. 3 x 30 mm [S_d x L_2]									
B 43	6 x 8	-	-	-	117453	100,000	149,200	10	B 43 3 AR 100 O5V STEEL EDGE
B 44	6 x 10	-	-	-	117460	100,000	141,100	10	B 44 3 AR 100 O5V STEEL EDGE
B 45	5 x 8	-	-	-	117477	130,000	181,900	10	B 45 3 AR 100 O5V STEEL EDGE
B 46	3 x 8	-	-	-	117484	150,000	267,100	10	B 46 3 AR 100 O5V STEEL EDGE
B 51	11 x 19	-	-	117507	-	60,000	63,600	10	B 51 3 AR 80 O5V STEEL EDGE
B 52	10 x 19	117514	-	117521	-	65,000	66,200	10	B 52 3 AR ... O5V STEEL EDGE
B 53	6 x 16	-	117545	-	117538	100,000	149,200	10	B 53 3 AR ... O5V STEEL EDGE
B 54	6 x 13	-	117569	-	117552	100,000	101,500	10	B 54 3 AR ... O5V STEEL EDGE
B 55	3 x 6	-	-	-	117576	150,000	257,000	10	B 55 3 AR 100 O5V STEEL EDGE
B 61	19 x 8	-	-	117590	-	35,000	45,000	10	B 61 3 AR 80 O5V STEEL EDGE
B 64	6 x 2	-	-	-	117637	100,000	149,200	10	B 64 3 AR 100 O5V STEEL EDGE
B 69	8 x 2	-	-	-	117668	85,000	120,800	10	B 69 3 AR 100 O5V STEEL EDGE
B 70	19 x 3	-	-	-	117675	35,000	49,900	10	B 70 3 AR 100 O5V STEEL EDGE
B 71	16 x 2	-	-	-	117682	42,000	60,000	10	B 71 3 AR 100 O5V STEEL EDGE
B 72	13 x 3	-	-	-	117699	50,000	75,100	10	B 72 3 AR 100 O5V STEEL EDGE
B 73	13 x 3	-	-	-	117705	50,000	75,100	10	B 73 3 AR 100 O5V STEEL EDGE
B 81	19 x 8	-	-	-	117712	35,000	49,900	10	B 81 3 AR 100 O5V STEEL EDGE
B 82	13 x 6	-	-	-	117736	50,000	75,100	10	B 82 3 AR 100 O5V STEEL EDGE
B 84	8 x 5	-	-	-	117750	85,000	120,800	10	B 84 3 AR 100 O5V STEEL EDGE
B 95	3 x 5	-	-	-	117798	150,000	260,300	10	B 95 3 AR 100 O5V STEEL EDGE
B 96	3 x 6	-	-	-	117804	150,000	236,100	10	B 96 3 AR 100 O5V STEEL EDGE
B 97	2 x 10	-	-	-	117811	107,300	107,300	10	B 97 3 AR 100 O5V STEEL EDGE
B 98	2 x 6	-	-	-	117828	150,000	168,300	10	B 98 3 AR 100 O5V STEEL EDGE
B 102	16 x 13	-	-	117842	-	42,000	46,400	10	B 102 3 AR 80 O5V STEEL EDGE
B 103	16 x 5	-	-	117866	-	42,000	60,000	10	B 103 3 AR 80 O5V STEEL EDGE
B 105	6 x 6	-	-	-	117880	100,000	149,200	10	B 105 3 AR 100 O5V STEEL EDGE
B 114	6 x 10	-	-	-	117958	100,000	136,900	10	B 114 3 AR 100 O5V STEEL EDGE
B 115	2 x 3	-	-	-	117965	150,000	299,400	10	B 115 3 AR 100 O5V STEEL EDGE
B 121	13	117972	-	-	-	50,000	56,200	10	B 121 3 AR 46 O5V STEEL EDGE
B 122	10	117996	-	118009	-	65,000	90,200	10	B 122 3 AR ... O5V STEEL EDGE
B 123	5	-	-	-	118016	130,000	198,900	10	B 123 3 AR 100 O5V STEEL EDGE
B 124	3	-	-	-	118023	150,000	291,800	10	B 124 3 AR 100 O5V STEEL EDGE
B 125	6	-	-	-	118030	100,000	149,200	10	B 125 3 AR 100 O5V STEEL EDGE
Shank dia. 3.17 x 30 mm [S_d x L_2]									
B 123	5	-	-	-	115701	130,000	198,900	10	B 123 3,1 AR 100 O5V STEEL EDGE
B 125	6	-	-	-	115732	100,000	149,200	10	B 125 3,1 AR 100 O5V STEEL EDGE

Mounted point set 2002 STEEL EDGE

Contains 15 small mounted points with shank diameter 3 mm in the most common shapes and dimensions for fine work.

Contents:

2 pieces each:
- ZY 0510
- ZY 0810
- ZY 1604

1 piece each:
- ZY 0408
- ZY 0613
- ZY 0802
- ZY 1013
- ZY 1303
- WR 0510
- KU 05
- SP 0306
- SP 0816

S_d [mm]	Grit size fine EAN 4007220		Description
3	114476	1	2002 O F STEEL EDGE

Mounted point set 2001 STEEL EDGE

Contains 10 mounted points with shank diameter 6 mm in the most common shapes and dimensions.

Contents:

1 piece each:
- ZY 1013
- ZY 1320
- ZY 2006
- ZY 2013
- ZY 2025
- KU 16
- WR 2025
- KE 2032
- SP 1320
- KE 2020

S_d [mm]	Grit size coarse EAN 4007220		Description
6	114469	1	2001 O G STEEL EDGE

Mounted points

For universal use on materials that are difficult to machine

TOUGH mounted points

The TOUGH type is specifically designed for use on titanium materials, nickel-based and cobalt-based alloys, hardened steel components and built-up weld deposits. Its applications include weld dressing on repair welds and reworking on turbine blades during aircraft maintenance and regrinding of repair welds in tool and mould-making.

Advantages:

- Cool grinding as the grain mixture is easy to break down.
- High stock removal rates and very long tool life.
- Constant stock removal rates through self-sharpening qualities of the ceramic oxide grain.

Materials that can be worked:

- Hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC)
- Titanium alloys
- Titanium
- High-temperature-resistant materials
- Nickel-based and cobalt-based alloys

Type:

- Vitrified bond
- Aluminium oxide mixture of ceramic oxide grain and white aluminium oxide

Recommendations for use:

- TOUGH mounted points perform best at a cutting speed of 30 to 50 m/s.

Matching tool drives:

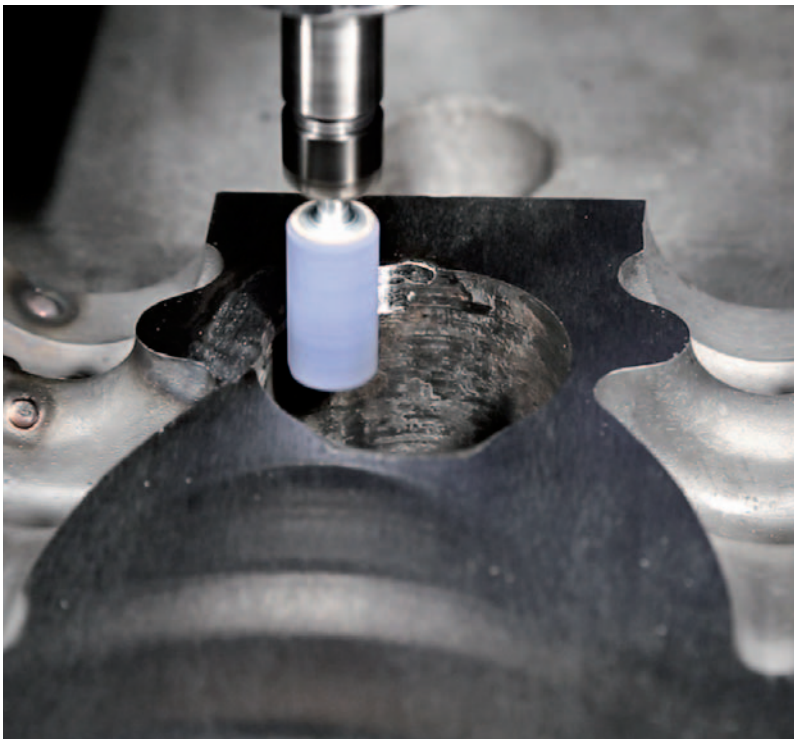
- Flexible shaft drive
- Straight grinder

Ordering notes:

- Please complete the description with the desired grit size.

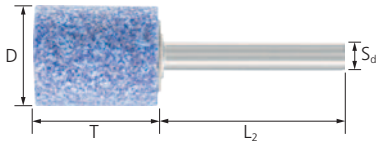
Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



TOUGH, cylindrical type

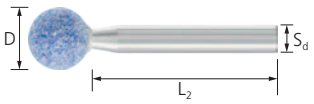
The cylindrical shape ZY is ideal for grinding bores, radii and contours.



D x T [mm]	Grit size							US shape	Opt. RPM	Max. RPM		Description
	24	30	46	60	80	100	320					
	EAN 4007220											
Shank dia. 3 x 30 mm [S_d x L_2]												
1 x 5	-	-	-	-	-	-	898383	-	104,200	104,200	10	ZY 0105 3 AWCO ... J5V TOUGH
1.5 x 8	-	-	-	-	-	-	898390	-	104,700	104,700	10	ZY 1,508 3 AWCO ... J5V TOUGH
1.7 x 8	-	-	-	-	-	-	898406	-	112,300	112,300	10	ZY 1,708 3 AWCO ... J5V TOUGH
2 x 5	-	-	-	-	898413	898420	-	W 141	150,000	201,800	10	ZY 0205 3 AWCO ... J5V TOUGH
3 x 6	-	-	-	898437	802106	802120	-	W 144	150,000	206,100	10	ZY 0306 3 AWCO ... J5V TOUGH
4 x 8	-	-	-	898444	802137	802144	-	-	150,000	175,100	10	ZY 0408 3 AWCO ... J5V TOUGH
5 x 10	-	-	-	898451	802151	802168	-	W 153	130,700	130,700	10	ZY 0510 3 AWCO ... J5V TOUGH
6 x 13	-	-	898468	802175	802182	802199	-	W 163	93,600	93,600	10	ZY 0613 3 AWCO ... J5V TOUGH
8 x 10	-	-	947852	-	-	-	-	W 169	87,600	87,600	10	ZY 0810 3 AWCO ... J5V TOUGH
8 x 16	-	-	898475	898499	898505	-	-	-	61,000	61,000	10	ZY 0816 3 AWCO ... J5V TOUGH
10 x 13	-	-	-	-	947869	-	-	W 176	58,400	58,400	10	ZY 1013 3 AWCO ... J5V TOUGH
13 x 3	-	-	-	898574	-	-	-	W 182	65,000	73,400	10	ZY 1303 3 AWCO ... J5V TOUGH
20 x 6	-	-	898581	898598	-	-	-	W 201	45,000	47,700	10	ZY 2006 3 AWCO ... J5V TOUGH
Shank dia. 6 x 40 mm [S_d x L_2]												
5 x 10	-	-	-	-	-	947876	-	W 153	150,000	157,800	10	ZY 0510 6 AWCO ... J5V TOUGH
8 x 16	-	-	802205	-	802212	-	-	-	100,000	119,300	10	ZY 0816 6 AWCO ... J5V TOUGH
10 x 13	-	-	802229	-	802274	-	-	W 176	85,000	95,400	10	ZY 1013 6 AWCO ... J5V TOUGH
10 x 20	-	-	898512	-	898550	-	-	-	85,000	95,400	10	ZY 1020 6 AWCO ... J5V TOUGH
13 x 25	-	-	802304	-	802311	-	-	W 187	65,000	66,000	10	ZY 1325 6 AWCO ... J5V TOUGH
16 x 20	-	947883	802328	802335	-	-	-	W 195	55,000	59,600	10	ZY 1620 6 AWCO ... J5V TOUGH
16 x 32	-	947890	802342	802366	-	-	-	-	51,200	51,200	10	ZY 1632 6 AWCO ... J5V TOUGH
20 x 25	-	947906	802373	802397	-	-	-	W 205	45,000	47,700	10	ZY 2025 6 AWCO ... J5V TOUGH
20 x 40	-	947913	898604	898628	-	-	-	W 207	32,400	32,400	10	ZY 2040 6 AWCO ... J5V TOUGH
25 x 25	-	947920	-	-	-	-	-	W 220	35,000	38,100	10	ZY 2525 6 AWCO ... J5V TOUGH
32 x 16	-	-	947937	-	-	-	-	-	27,000	29,800	5	ZY 3216 6 AWCO ... J5V TOUGH
32 x 32	947944	-	802427	-	-	-	-	W 230	25,700	25,700	5	ZY 3232 6 AWCO ... J5V TOUGH
40 x 10	-	-	898635	898642	-	-	-	W 236	22,000	23,800	5	ZY 4010 6 AWCO ... J5V TOUGH
40 x 20	-	-	802434	-	-	-	-	-	22,000	23,800	5	ZY 4020 6 AWCO ... J5V TOUGH

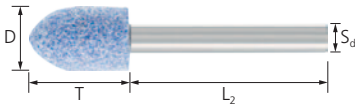
TOUGH, ball type

The ball shape KU is often used for contour grinding and backside deburring.



D [mm]	Grit size				Opt. RPM	Max. RPM		Description
	46	60	80	100				
	EAN 4007220							
Shank dia. 3 x 30 mm [S_d x L_2]								
3	-	898659	898666	-	150,000	300,200	10	KU 03 3 AWCO ... J5V TOUGH
6	-	898673	802465	802472	140,000	159,100	10	KU 06 3 AWCO ... J5V TOUGH
8	898680	-	802489	802519	100,000	116,200	10	KU 08 3 AWCO ... J5V TOUGH
Shank dia. 6 x 40 mm [S_d x L_2]								
13	802533	802557	802595	-	65,000	73,400	10	KU 13 6 AWCO ... J5V TOUGH

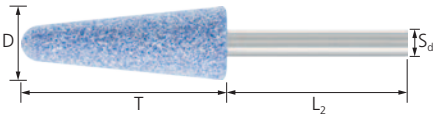
Mounted points
For universal use on materials that are difficult to machine



TOUGH, pointed tree type

The pointed tree shape SP is excellent for machining small holes and bores.

D x T [mm]	Grit size 46	60	80	100	Opt. RPM	Max. RPM		Description
	EAN 4007220							
Shank dia. 3 x 30 mm [S_d x L_2]								
3 x 6	-	898697	898703	898734	150,000	252,000	10	SP 0306 3 AWCO ... J5V TOUGH
4 x 8	-	-	898758	898765	150,000	195,400	10	SP 0408 3 AWCO ... J5V TOUGH
5 x 10	-	-	-	948071	149,500	149,500	10	SP 0510 3 AWCO ... J5V TOUGH
6 x 10	-	898789	-	-	134,100	134,100	10	SP 0610 3 AWCO ... J5V TOUGH
6 x 13	898772	-	802663	802670	108,100	108,100	10	SP 0613 3 AWCO ... J5V TOUGH
8 x 16	898796	802687	802694	802700	72,800	72,800	10	SP 0816 3 AWCO ... J5V TOUGH
Shank dia. 6 x 40 mm [S_d x L_2]								
13 x 20	802717	802724	802731	-	65,000	73,400	10	SP 1320 6 AWCO ... J5V TOUGH

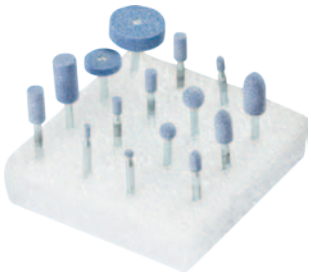


TOUGH, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.

D x T [mm]	Grit size 46	60	Opt. RPM	Max. RPM		Description
	EAN 4007220					
Shank dia. 6 x 40 mm [S_d x L_2]						
10 x 25	802601	802618	85,000	95,400	10	KE 1025 6 AWCO ... J5V TOUGH
16 x 45	802625	802656	52,000	52,000	10	KE 1645 6 AWCO ... J5V TOUGH

Mounted point set 2002 TOUGH



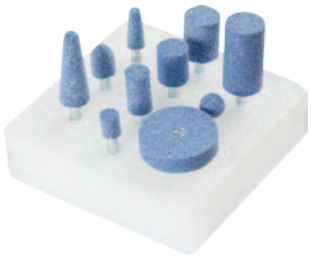
Contains 15 small mounted points with shank diameter 3 mm in the most common shapes and dimensions for fine work.

Contents:
1 piece each:

- ZY 0205
- ZY 0306
- ZY 0408
- ZY 0510
- ZY 0613
- ZY 0816
- ZY 1303
- ZY 2006
- KU 03
- KU 06
- KU 08
- SP 0306
- SP 0408
- SP 0613
- SP 0816

S_d [mm]	Grit size fine EAN 4007220		Description
3	947616	1	2002 J F TOUGH

Mounted point set 2001 TOUGH



Contains 10 mounted points with shank diameter 6 mm in the most common shapes and dimensions.

Contents:
1 piece each:

- ZY 1013
- ZY 1325
- ZY 1620
- ZY 2025
- ZY 2040
- ZY 4010
- KU 13
- SP 1320
- KE 1025
- KE 1645

S_d [mm]	Grit size coarse EAN 4007220		Description
6	947609	1	2001 J G TOUGH

Mounted points
For universal use on stainless steel (INOX)

INOX mounted points

The INOX type is particularly well suited to surface work on stainless steel (INOX) and for universal use on non-ferrous metals and bronze. These tools are used for rough grinding of stainless steel (INOX) castings and grinding of moulded parts made of high-temperature-resistant alloys.

Advantages:

- Due to cool grinding, very suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.

Materials that can be worked:

- Stainless steel (INOX)
- Bronze
- Hard non-ferrous metals

Type:

- Resinoid bond
- Aluminium oxide mixture of dark-red and white aluminium oxide

Recommendations for use:

- INOX mounted points perform best at a cutting speed of 35 to 50 m/s.

Matching tool drives:

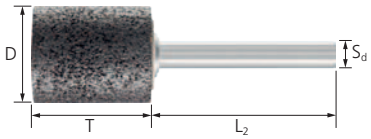
- Flexible shaft drive
- Straight grinder

Ordering notes:

- Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



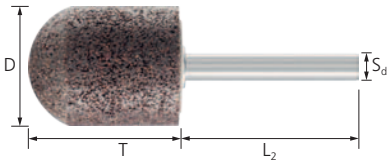
INOX, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

D x T [mm]	Grit size				US shape	Opt. RPM	Max. RPM		Description
	24	30	46	60					
	EAN 4007220								
Shank dia. 6 x 40 mm [S_d x L_2]									
8 x 16	-	-	346877	-	-	100,000	119,300	10	ZY 0816 6 ADW ... L6B INOX
10 x 20	-	-	346891	-	W 177	90,000	95,400	10	ZY 1020 6 ADW ... L6B INOX
10 x 32	-	-	346907	-	W 179	62,800	62,800	10	ZY 1032 6 ADW ... L6B INOX
16 x 32	-	096697	-	-	-	51,200	51,200	10	ZY 1632 6 ADW ... L6B INOX
20 x 25	-	097083	-	346914	W 205	45,000	47,700	10	ZY 2025 6 ADW ... L6B INOX
20 x 40	-	097304	-	-	W 207	32,400	32,400	10	ZY 2040 6 ADW ... L6B INOX
25 x 13	-	099483	-	-	W 218	37,000	38,100	10	ZY 2513 6 ADW ... L6B INOX
25 x 25	-	346938	-	-	W 220	37,000	38,100	10	ZY 2525 6 ADW ... L6B INOX
25 x 32	-	097533	-	-	-	32,900	32,900	10	ZY 2532 6 ADW ... L6B INOX
32 x 16	099742	-	-	-	-	29,000	29,800	5	ZY 3216 6 ADW ... L6B INOX
32 x 40	097793	-	-	-	W 231	20,300	20,300	5	ZY 3240 6 ADW ... L6B INOX
40 x 6	-	-	-	346976	W 235	23,000	23,800	5	ZY 4006 6 ADW ... L6B INOX
40 x 10	-	099940	-	-	W 236	23,000	23,800	5	ZY 4010 6 ADW ... L6B INOX
40 x 20	100127	-	-	-	-	23,000	23,800	5	ZY 4020 6 ADW ... L6B INOX
50 x 13	-	100271	-	-	-	19,000	19,000	5	ZY 5013 6 ADW ... L6B INOX
50 x 25	100394	-	-	-	W 242	19,000	19,000	5	ZY 5025 6 ADW ... L6B INOX
Shank dia. 8 x 40 mm [S_d x L_2]									
32 x 40	098257	-	-	-	W 231	28,500	29,800	5	ZY 3240 8 ADW ... L6B INOX
50 x 40	100653	-	-	-	W 243	19,000	19,000	5	ZY 5040 8 ADW ... L6B INOX

INOX, cylindrical with radius end type

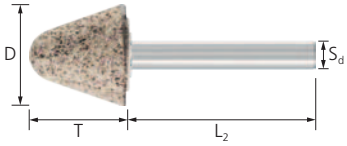
The cylindrical shape with radius end WR is suitable for a variety of deburring and grinding jobs.



D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM		Description
Shank dia. 6 x 40 mm [S_d x L_2]					
25 x 32	353813	37,000	37,300	10	WR 2532 6 ADW 30 L6B INOX

INOX, conical with radius end type

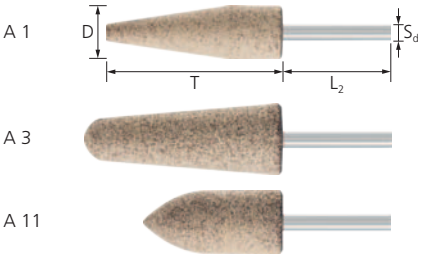
The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.



D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM		Description
Shank dia. 6 x 40 mm [S_d x L_2]					
20 x 20	347034	45,000	47,700	10	KE 2020 6 ADW 30 L6B INOX
25 x 45	660331	34,000	34,000	10	KE 2545 6 ADW 30 L6B INOX

Series A INOX

Series A mounted points are generally used on larger, stainless steel components, such as in container construction. Due to the special shapes of series A mounted points, it is possible to grind in a variety of contours. The applications range from grinding in hard-to-reach areas to machining bores and small holes as well as smoothing.



US shape	D x T [mm]	Grit size 60 EAN 4007220	Opt. RPM	Max. RPM		Description
Shank dia. 6 x 40 mm [S_d x L_2]						
A 1	19 x 64	347096	30,400	30,400	10	A 1 6 ADW 60 L6B INOX
A 3	25 x 70	347119	18,600	18,600	10	A 3 6 ADW 60 L6B INOX
A 11	22 x 50	347133	27,600	27,600	10	A 11 6 ADW 60 L6B INOX

Mounted points
For edge grinding on stainless steel (INOX)

INOX EDGE mounted points

The INOX EDGE type is particularly well suited to edge grinding on stainless steel (INOX).
Its applications include weld dressing on fillet welds on stainless steel components, removing burrs on moulded parts made of high-temperature-resistant alloys, removing burrs on stainless steel castings and grinding chamfers in preparation for welding stainless steel profiles.

Advantages:

- Due to cool grinding, particularly suitable for use on temperature-sensitive materials.
- High level of grinding comfort due to low-vibration grinding.
- Economical to use due to the high edge stability even on low-speed tool drives.
- High dimensional stability on edges.

Materials that can be worked:

- Stainless steel (INOX)

Type:

- Resinoid bond
- Regular aluminium oxide

Recommendations for use:

- INOX EDGE mounted points perform best at a cutting speed of 35 to 50 m/s.

Matching tool drives:

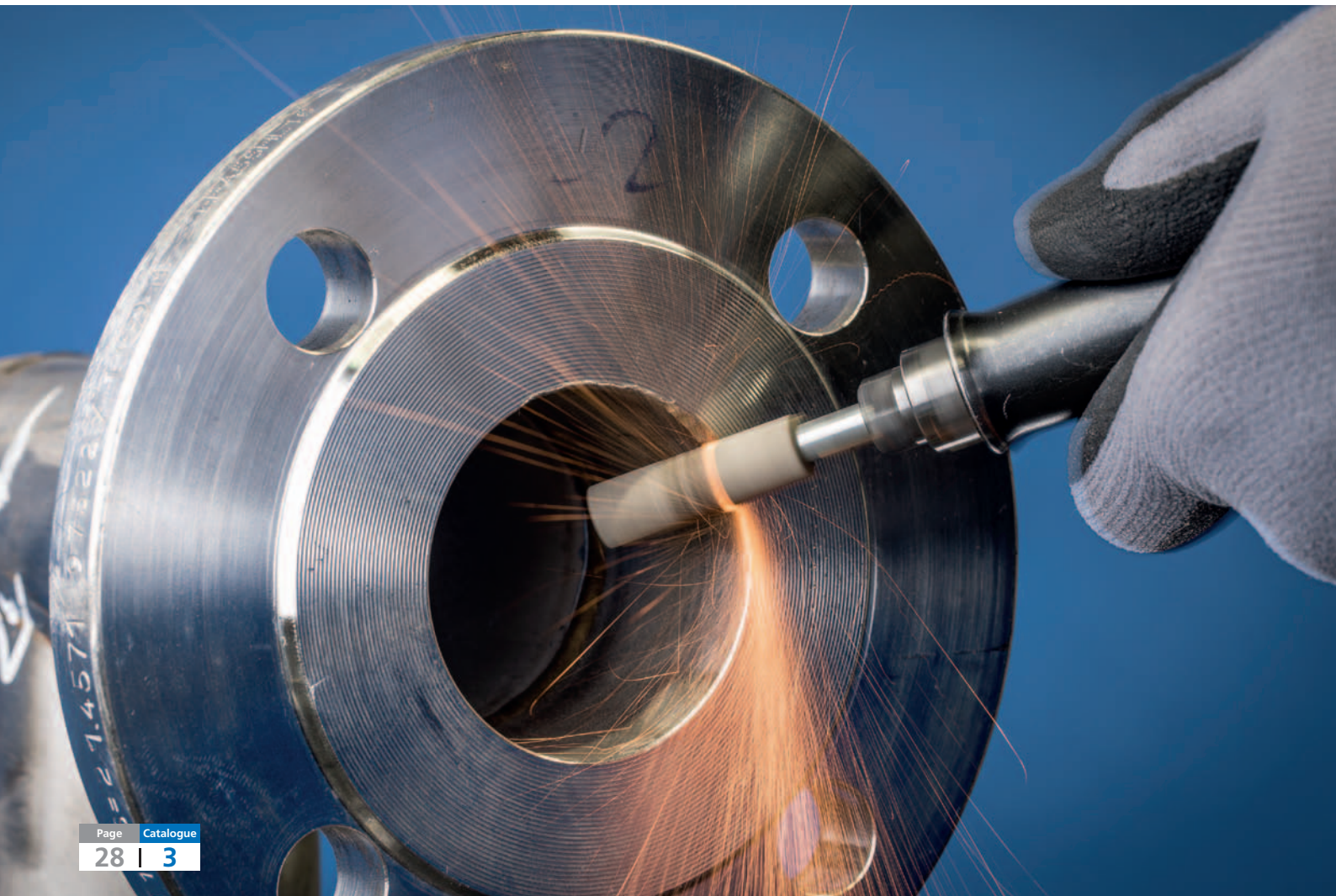
- Flexible shaft drive
- Straight grinder

Ordering notes:

- Please complete the description with the desired grit size.

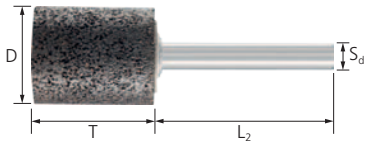
Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



INOX EDGE, cylindrical type

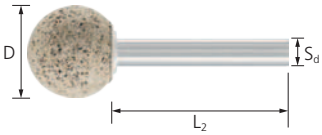
The cylindrical shape ZY is ideal for grinding bores, radii and contours.



D x T [mm]	Grit size 24	30	46	60	US shape	Opt. RPM	Max. RPM		Description
	EAN 4007220								
Shank dia. 6 x 40 mm [S_d x L_2]									
8 x 16	-	-	346860	-	-	100,000	119,300	10	ZY 0816 6 AN ... N5B INOX EDGE
10 x 20	-	-	346884	-	W 177	92,000	95,400	10	ZY 1020 6 AN ... N5B INOX EDGE
10 x 32	-	-	096062	-	W 179	62,800	62,800	10	ZY 1032 6 AN ... N5B INOX EDGE
13 x 25	-	-	096420	-	W 187	66,000	66,000	10	ZY 1325 6 AN ... N5B INOX EDGE
16 x 32	-	096673	-	096680	-	51,200	51,200	10	ZY 1632 6 AN ... N5B INOX EDGE
16 x 50	-	096871	-	-	W 197	31,300	31,300	10	ZY 1650 6 AN ... N5B INOX EDGE
20 x 8	-	346952	-	-	-	46,000	47,700	10	ZY 2008 6 AN ... N5B INOX EDGE
20 x 25	-	097076	-	-	W 205	46,000	47,700	10	ZY 2025 6 AN ... N5B INOX EDGE
20 x 40	-	097298	-	-	W 207	32,400	32,400	10	ZY 2040 6 AN ... N5B INOX EDGE
25 x 6	-	-	346969	-	W 216	37,000	38,100	10	ZY 2506 6 AN ... N5B INOX EDGE
25 x 13	-	099476	-	-	W 218	37,000	38,100	10	ZY 2513 6 AN ... N5B INOX EDGE
25 x 32	-	097526	-	-	-	32,900	32,900	10	ZY 2532 6 AN ... N5B INOX EDGE
25 x 40	-	098141	-	-	W 221	26,000	26,000	10	ZY 2540 6 AN ... N5B INOX EDGE
32 x 8	-	099629	-	-	W 226	29,000	29,800	5	ZY 3208 6 AN ... N5B INOX EDGE
32 x 16	099735	-	-	-	-	29,000	29,800	5	ZY 3216 6 AN ... N5B INOX EDGE
32 x 20	099834	-	-	-	W 228	29,000	29,800	5	ZY 3220 6 AN ... N5B INOX EDGE
32 x 32	097670	-	-	-	W 230	25,700	25,700	5	ZY 3232 6 AN ... N5B INOX EDGE
32 x 40	097786	-	-	-	W 231	20,300	20,300	5	ZY 3240 6 AN ... N5B INOX EDGE
40 x 6	-	-	100479	-	W 235	23,000	23,800	5	ZY 4006 6 AN ... N5B INOX EDGE
40 x 10	-	099933	-	-	-	23,000	23,800	5	ZY 4010 6 AN ... N5B INOX EDGE
40 x 20	100110	-	-	-	-	23,000	23,800	5	ZY 4020 6 AN ... N5B INOX EDGE
40 x 40	346945	-	-	-	W 238	16,200	16,200	5	ZY 4040 6 AN ... N5B INOX EDGE
50 x 8	-	100523	-	-	-	19,000	19,000	5	ZY 5008 6 AN ... N5B INOX EDGE
50 x 13	-	100264	-	-	-	19,000	19,000	5	ZY 5013 6 AN ... N5B INOX EDGE
50 x 25	100387	-	-	-	W 242	19,000	19,000	5	ZY 5025 6 AN ... N5B INOX EDGE
Shank dia. 8 x 40 mm [S_d x L_2]									
32 x 40	098240	-	-	-	W 231	28,500	29,800	5	ZY 3240 8 AN ... N5B INOX EDGE

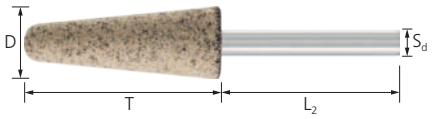
INOX EDGE, ball type

The ball shape KU is often used for contour grinding and backside deburring.



D [mm]	Grit size 30	Opt. RPM	Max. RPM		Description
	EAN 4007220				
Shank dia. 6 x 40 mm [S_d x L_2]					
16	347003	58,000	59,600	10	KU 16 6 AN 30 N5B INOX EDGE
20	347010	46,000	47,700	10	KU 20 6 AN 30 N5B INOX EDGE
25	347027	37,000	38,100	10	KU 25 6 AN 30 N5B INOX EDGE

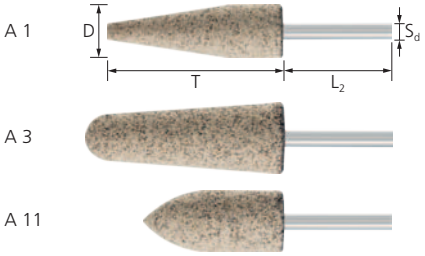
Mounted points
For edge grinding on stainless steel (INOX)



INOX EDGE, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.

D x T [mm]	Grit size 24	Grit size 30	Grit size 46	Opt. RPM	Max. RPM		Description
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
10 x 25	-	-	347041	92,000	95,400	10	KE 1025 6 AN ... N5B INOX EDGE
16 x 45	-	-	347065	52,000	52,000	10	KE 1645 6 AN ... N5B INOX EDGE
25 x 45	-	660324	-	34,000	34,000	10	KE 2545 6 AN ... N5B INOX EDGE
32 x 32	347072	-	-	29,000	29,800	5	KE 3232 6 AN ... N5B INOX EDGE



Series A INOX EDGE

Series A mounted points are generally used on larger, stainless steel components, such as in container construction. Due to the special shapes of series A mounted points, it is possible to grind in a variety of contours. The applications range from grinding in hard-to-reach areas to machining bores and small holes as well as smoothing.

US shape	D x T [mm]	Grit size 30	Opt. RPM	Max. RPM		Description
		EAN 4007220				
Shank dia. 6 x 40 mm [S_d x L_2]						
A 1	19 x 64	347089	30,400	30,400	10	A 1 6 AN 30 N5B INOX EDGE
A 3	25 x 70	347102	18,600	18,600	10	A 3 6 AN 30 N5B INOX EDGE
A 11	22 x 50	347126	27,600	27,600	10	A 11 6 AN 30 N5B INOX EDGE
Shank dia. 6.35 x 40 mm [S_d x L_2]						
A 11	22 x 50	347157	30,400	30,400	10	A 11 6,3 AN 30 N5B INOX EDGE

ALU mounted points

The ALU type is particularly well suited to universal use on aluminium and non-ferrous metals. It is used to remove burrs on cast aluminium parts and for chamfering on aluminium profiles for weld-seam preparation.

Advantages:

- The special impregnation means there is no clogging when working on soft, lubricating or tough materials.
- Good grinding performance and stock removal rate.

Materials that can be worked:

- Aluminium
- Copper
- Brass
- Zinc

Type:

- Vitrified bond
- Green silicon carbide

Recommendations for use:

- ALU mounted points perform best at a cutting speed of 20 to 40 m/s.

Matching tool drives:

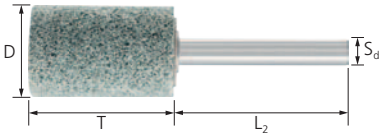
- Flexible shaft drive
- Straight grinder

Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.

ALU, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours. It can be made into any desired shape with the aid of a dressing stone.



D x T [mm]	Grit size 80 EAN 4007220	US shape	Opt. RPM	Max. RPM		Description
Shank dia. 3 x 30 mm [S_d x L_2]						
3 x 6	948101	W 144	150,000	206,100	10	ZY 0306 3 CN 80 F10V ALU
6 x 13	948118	W 163	93,600	93,600	10	ZY 0613 3 CN 80 F10V ALU
Shank dia. 6 x 40 mm [S_d x L_2]						
10 x 13	802908	W 176	45,000	95,400	10	ZY 1013 6 CN 80 F10V ALU
13 x 20	802915	W 186	35,000	73,400	10	ZY 1320 6 CN 80 F10V ALU
16 x 20	096512	W 195	30,000	59,600	10	ZY 1620 6 CN 80 F10V ALU
16 x 32	802939	-	30,000	51,200	10	ZY 1632 6 CN 80 F10V ALU
20 x 32	097151	W 206	24,000	41,100	10	ZY 2032 6 CN 80 F10V ALU
32 x 32	802946	W 230	15,000	25,700	5	ZY 3232 6 CN 80 F10V ALU
40 x 20	100080	-	12,000	23,800	5	ZY 4020 6 CN 80 F10V ALU

Mounted points
For surface grinding on grey and nodular cast iron

CAST mounted points

The CAST type is particularly well suited to surface work on grey and nodular cast iron in combination with high peripheral speeds. Its applications include cleaning of workpieces and grinding out of shrinkage holes.

Advantages:

- Suitable for use on surfaces and edges.
- Good grinding performance and long tool life.
- High stock removal rates thanks to coarse grit size.

Materials that can be worked:

- Grey/nodular cast iron (GG/GJL, GGG/GJS)
- Annealed cast iron

Type:

- Vitrified bond
- Aluminium oxide mixture of pink aluminium oxide and regular aluminium oxide

Recommendations for use:

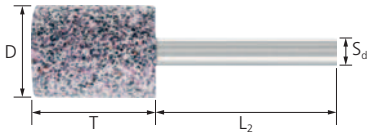
- CAST mounted points perform best at a cutting speed of 30 to 50 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Safety notes:

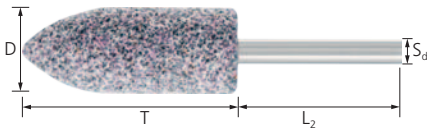
- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



CAST, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

D x T [mm]	Grit size 24	Grit size 30	US shape	Opt. RPM	Max. RPM		Description
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
16 x 32	-	096567	-	51,200	51,200	10	ZY 1632 6 ARN 30 K5V CAST
16 x 50	-	096819	W 197	31,300	31,300	10	ZY 1650 6 ARN 30 K5V CAST
20 x 25	-	096963	W 205	43,000	47,700	10	ZY 2025 6 ARN 30 K5V CAST
20 x 40	-	097199	W 207	32,400	32,400	10	ZY 2040 6 ARN 30 K5V CAST
25 x 32	-	097410	-	32,900	32,900	10	ZY 2532 6 ARN 30 K5V CAST
32 x 32	097564	-	W 230	25,700	25,700	5	ZY 3232 6 ARN 24 K5V CAST
32 x 40	097694	-	W 231	20,300	20,300	5	ZY 3240 6 ARN 24 K5V CAST
40 x 10	-	099865	W 236	22,000	23,800	5	ZY 4010 6 ARN 30 K5V CAST
40 x 20	100004	-	-	22,000	23,800	5	ZY 4020 6 ARN 24 K5V CAST
50 x 8	-	100493	-	18,000	19,000	5	ZY 5008 6 ARN 30 K5V CAST
50 x 13	-	100165	-	18,000	19,000	5	ZY 5013 6 ARN 30 K5V CAST
Shank dia. 8 x 40 mm [S_d x L_2]							
32 x 40	098158	-	W 231	27,000	29,800	5	ZY 3240 8 ARN 24 K5V CAST
50 x 25	100530	-	W 242	18,000	19,000	5	ZY 5025 8 ARN 24 K5V CAST



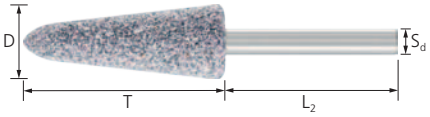
CAST, pointed tree type

The pointed tree shape SP is excellent for machining small holes and bores.

D x T [mm]	Grit size 30	Opt. RPM	Max. RPM		Description
	EAN 4007220				
Shank dia. 6 x 40 mm [S_d x L_2]					
20 x 50	102305	30,500	30,500	10	SP 2050 6 ARN 30 K5V CAST

CAST, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.

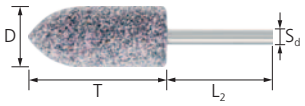


D x T [mm]	Grit size 24	Grit size 46	Opt. RPM	Max. RPM		Description
	EAN 4007220					
Shank dia. 6 x 40 mm [S_d x L_2]						
10 x 25	-	534649	85,000	95,400	10	KE 1025 6 ARN 46 K5V CAST
16 x 45	-	102848	52,000	52,000	10	KE 1645 6 ARN 46 K5V CAST
20 x 40	534694	-	43,000	47,700	10	KE 2040 6 ARN 24 K5V CAST
Shank dia. 8 x 40 mm [S_d x L_2]						
32 x 50	103081	-	27,000	29,800	5	KE 3250 8 ARN 24 K5V CAST

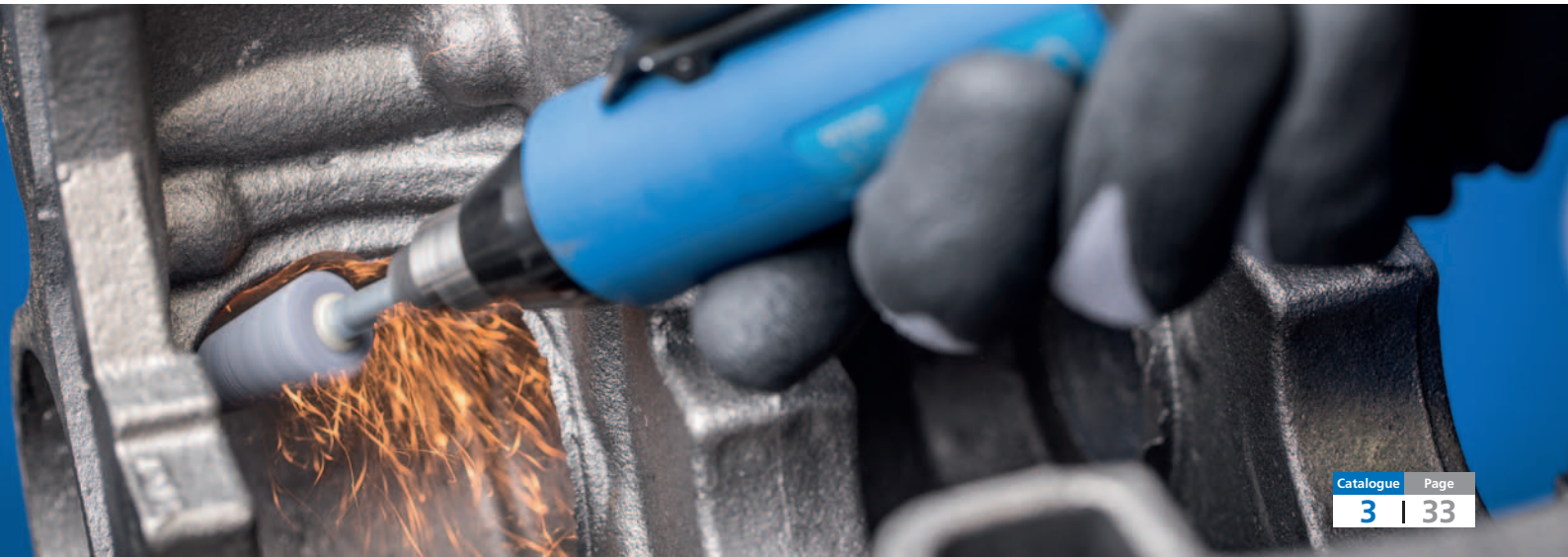
Series A CAST

The shape A 11 is excellent for machining small holes and bores.

A 11



US shape	D x T [mm]	Grit size 30	Opt. RPM	Max. RPM		Description
		EAN 4007220				
Shank dia. 6 x 40 mm [S_d x L_2]						
A 11	22 x 50	534700	27,600	27,600	10	A 11 6 ARN 30 K5V CAST



Mounted points
For edge grinding on grey and nodular cast iron

CAST EDGE mounted points

The CAST EDGE type is particularly well suited to edge grinding and grinding out sand contamination and metal contamination on grey and nodular cast iron in combination with high cutting speeds. Its main applications include removal of sharp burrs and grinding of sand contamination and metal contamination on cast parts.

Advantages:

- Highly dimensionally stable due to the high bond content.
- Economical to use due to the high edge stability even on low-speed tool drives.

Materials that can be worked:

- Grey/nodular cast iron (GG/GJL, GGG/GJS)
- Annealed cast iron
- Casting scale with sand contamination and metal contamination

Type:

- Vitrified bond
- Grey silicon carbide

Recommendations for use:

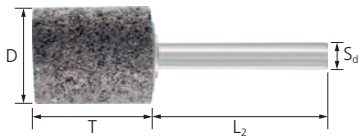
- CAST EDGE mounted points perform best at a cutting speed of 30 to 50 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Safety notes:

- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



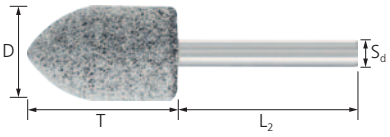
CAST EDGE, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

D x T [mm]	Grit size 24	Grit size 30	US shape	Opt. RPM	Max. RPM		Description
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
16 x 32	-	096666	-	47,000	51,200	10	ZY 1632 6 CU 30 R5V CAST EDGE
20 x 25	-	097069	W 205	38,000	47,700	10	ZY 2025 6 CU 30 R5V CAST EDGE
20 x 40	-	097281	-	32,400	32,400	10	ZY 2040 6 CU 30 R5V CAST EDGE
20 x 50	-	098097	W 208	25,100	25,100	10	ZY 2050 6 CU 30 R5V CAST EDGE
32 x 32	097663	-	W 230	23,000	25,700	5	ZY 3232 6 CU 24 R5V CAST EDGE
40 x 20	100103	-	-	19,000	23,800	5	ZY 4020 6 CU 24 R5V CAST EDGE
Shank dia. 8 x 40 mm [S_d x L_2]							
32 x 40	098233	-	W 231	24,000	29,800	5	ZY 3240 8 CU 24 R5V CAST EDGE
40 x 40	098301	-	W 238	19,000	23,800	5	ZY 4040 8 CU 24 R5V CAST EDGE

CAST EDGE, pointed tree type

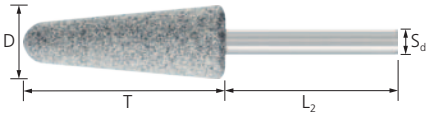
The pointed tree shape SP is excellent for machining small holes and bores.



D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM		Description
Shank dia. 6 x 40 mm [S_d x L_2]					
20 x 32	102282	38,000	47,700	10	SP 2032 6 CU 30 R5V CAST EDGE
20 x 50	102336	30,500	30,500	10	SP 2050 6 CU 30 R5V CAST EDGE

CAST EDGE, conical with radius end type

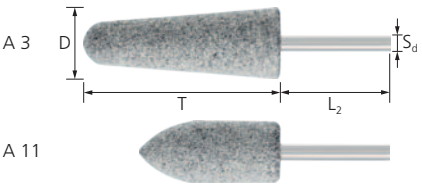
The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.



D x T [mm]	Grit size 30	46	Opt. RPM	Max. RPM		Description
	EAN 4007220					
Shank dia. 6 x 40 mm [S_d x L_2]						
16 x 45	-	102916	47,000	52,000	10	KE 1645 6 CU 46 R5V CAST EDGE
20 x 32	102725	-	38,000	47,700	10	KE 2032 6 CU 30 R5V CAST EDGE
25 x 45	102947	-	30,000	34,000	10	KE 2545 6 CU 30 R5V CAST EDGE

Series A CAST EDGE

The shape A 3 is designed for a comfortable working position during surface grinding and grinding of chamfers.
The shape A 11 is excellent for machining small holes and bores.



US shape	D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM		Description
Shank dia. 6 x 40 mm [S_d x L_2]						
A 3	25 x 70	117156	18,600	18,600	10	A 3 6 CU 30 R5V CAST EDGE
A 11	22 x 50	117217	27,600	27,600	10	A 11 6 CU 30 R5V CAST EDGE

Mounted points
For edge grinding on grey and nodular cast iron

CAST EDGE mounted points for foundries

The CAST EDGE type for foundries is particularly well suited to universal use and for grinding out metal contamination and grinding of sand contamination and sand deposits on grey and nodular cast iron workpieces in conjunction with high cutting speeds.

Advantages:

- Excellent grinding performance and aggressiveness from the start.
- High stock removal rate in combination with a long tool life.
- Delivered in practical and environmentally friendly industrial packaging.

Materials that can be worked:

- Grey/nodular cast iron (GG/GJL, GGG/GJS)
- Annealed cast iron
- Casting scale with sand contamination and metal contamination

Type:

- Vitrified bond
- Grey silicon carbide

Recommendations for use:

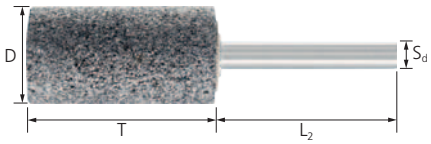
- CAST EDGE mounted points perform best at a cutting speed of 30 to 50 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Safety notes:

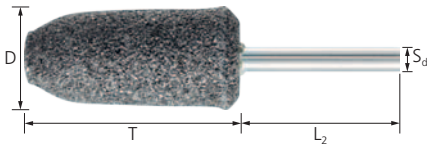
- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



CAST EDGE, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

D x T [mm]	Grit size 30 EAN 4007220	US shape	Opt. RPM	Max. RPM	IP	Description
Shank dia. 6 x 40 mm [S_d x L_2]						
20 x 40	803028	W 205	32,400	32,400	50	ZY 2040 6 CU 30 R5V CAST EDGE N
25 x 32	803035	-	30,000	32,900	50	ZY 2532 6 CU 30 R5V CAST EDGE N



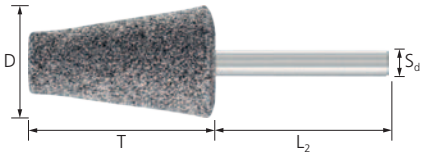
CAST EDGE, pointed tree type

The pointed tree shape SP is excellent for machining small holes and bores.

D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM	IP	Description
Shank dia. 6 x 40 mm [S_d x L_2]					
20 x 50	803042	14,100	14,100	50	SP 2050 6 CU 30 R5V CAST EDGE N

CAST EDGE, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.



D x T [mm]	Grit size			Opt. RPM	Max. RPM	IP	Description
	24	30	46				
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
16 x 45	-	-	803059	24,000	24,000	50	KE 1645 6 CU 46 R5V CAST EDGE N
20 x 40	-	803066	-	20,900	20,900	50	KE 2040 6 CU 30 R5V CAST EDGE N
Shank dia. 8 x 40 mm [S_d x L_2]							
35 x 50	642665	-	-	15,600	15,600	50	KE 3550 8 CU 24 R5V CAST EDGE N

Mounted points
For universal use on cast steel

CAST STEEL mounted points for foundries

The CAST STEEL type is particularly well suited to tough universal work on cast steel. It is ideal for removing burrs on cast steel parts and for grinding of intersections after separating risers.

Advantages:

- Excellent grinding performance and aggressiveness from the start.
- High stock removal rate in combination with a long tool life.
- Delivered in practical and environmentally friendly industrial packaging.

Materials that can be worked:

- Cast steel

Type:

- Vitrified bond
- Aluminium oxide mixture of pink and dark-red aluminium oxide

Recommendations for use:

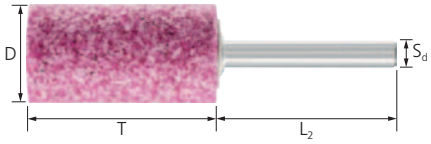
- CAST STEEL mounted points perform best at a cutting speed of 25 to 40 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Safety notes:

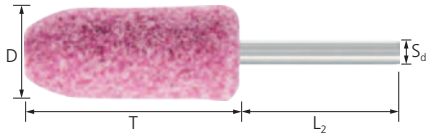
- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



CAST STEEL, cylindrical type

The cylindrical shape ZY is ideal for grinding bores, radii and contours.

D x T [mm]	Grit size 30 EAN 4007220	US shape	Opt. RPM	Max. RPM	IP	Description
Shank dia. 6 x 40 mm [S_d x L_2]						
20 x 40	802953	W 207	32,400	32,400	50	ZY 2040 6 ADR 30 O5V CAST STEEL
25 x 32	802960	-	25,000	32,900	50	ZY 2532 6 ADR 30 O5V CAST STEEL



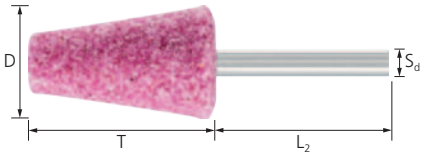
CAST STEEL, pointed tree type

The pointed tree shape SP is excellent for machining small holes and bores.

D x T [mm]	Grit size 30 EAN 4007220	Opt. RPM	Max. RPM	IP	Description
Shank dia. 6 x 40 mm [S_d x L_2]					
20 x 50	802977	14,100	14,100	50	SP 2050 6 ADR 30 O5V CAST STEEL

CAST STEEL, conical with radius end type

The conical shape with radius end KE is designed for a comfortable working position during surface grinding and grinding of chamfers.



D x T [mm]	Grit size			Opt. RPM	Max. RPM	IP	Description
	24	30	46				
	EAN 4007220						
Shank dia. 6 x 40 mm [S_d x L_2]							
16 x 45	-	-	802991	24,000	24,000	50	KE 1645 6 ADR 46 O5V CAST STEEL
20 x 40	-	803011	-	20,900	20,900	50	KE 2040 6 ADR 30 O5V CAST STEEL
Shank dia. 8 x 40 mm [S_d x L_2]							
35 x 50	642672	-	-	15,600	15,600	50	KE 3550 8 ADR 24 O5V CAST STEEL

RUBBER mounted points

The RUBBER type is specifically designed for universal use on soft materials such as rubber, plastic and wood. The fields of application include removal of burrs on plastic injection-moulded parts, trimming of rubber moulded parts and moulded parts made of polyurethane (PUR), grinding of wooden cores and wooden shapes in model construction workshops and roughening of various adhesive joints (e.g. for repairs on conveyor belts and tyres).

Advantages:

- Open structure and large chip spaces due to bubble grain aluminium oxide.
- Machining of temperature-sensitive materials without addition of cooling lubricant due to large chip spaces.
- Excellent grinding performance.

Materials that can be worked:

- Elastomers
- Thermoplastics
- Rubber
- Wood

Type:

- Vitrified bond
- Bubble grain aluminium oxide

Recommendations for use:

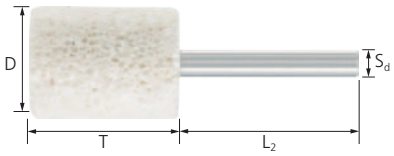
- RUBBER mounted points perform best at a cutting speed of 5 to 20 m/s.

Matching tool drives:

- Flexible shaft drive
- Straight grinder

Safety notes:

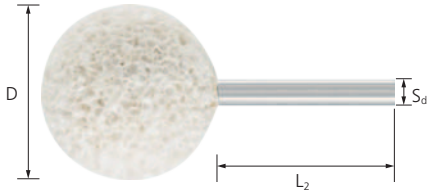
- The maximum permitted rotational speed relates to the unsupported shank length of 10 mm.



RUBBER, cylindrical type

The cylindrical shape ZY is ideal for grinding radii and contours, and for deburring work.

D x T [mm]	Grit size 1	Grit size 2	Opt. RPM	Max. RPM		Description
	EAN 4007220					
Shank dia. 6 x 40 mm [S_d x L_2]						
16 x 32	096703	-	12,000	51,200	10	ZY 1632 6 AH 1 D12V RUBBER
25 x 32	097540	-	8,000	32,900	10	ZY 2532 6 AH 1 D12V RUBBER
40 x 20	-	100134	5,000	23,800	5	ZY 4020 6 AH 2 D12V RUBBER



RUBBER, ball type

The ball shape KU is often used for roughening rubber surfaces in tyre repair.

D [mm]	Grit size 2	Opt. RPM	Max. RPM		Description
	EAN 4007220				
Shank dia. 6 x 40 mm [S_d x L_2]					
40	948095	5,000	19,700	5	KU 40 6 AH 2 D12V RUBBER

PFERD offers a very wide range of high-quality bench grinding wheels for working with a large variety of materials and for many different applications.
Bench grinding wheels are available with different dimensions, grains and abrasives.
The PFERD range has been adapted to the standard bench grinders on the market.

Advantages:

- Long tool life.
- High dimensional stability.
- High abrasive performance.
- Integrated adapter sleeves for mounting on almost any bench grinder spindle.

Applications:

- Deburring
- Work on edges (chamfering, rounding)
- Sharpening

Recommendations for use:

- Dressing the wheel on a regular basis exposes sharp grain and maintains an even grinding area.
- Constantly adjust the workpiece support to the grinding wheel diameter (gap width max. 3 mm).

Matching tool drives:

- Bench grinders

Ordering notes:

- Please complete the description with the desired grit size.

Safety notes:

- The maximum permitted peripheral speed is 35 m/s.
- For safety reasons, the maximum permitted rotational speed indicated must never be exceeded.
- Before clamping, the grinding tool must be ring tested to make sure that it does not have any cracks (undamaged grinding tools give a clear tone).

 = Wear eye protection!

 = Wear a dust mask!

 = Wear hearing protection!

 = Wear gloves!

 = Follow the safety instructions!

 = Do not use if damaged!

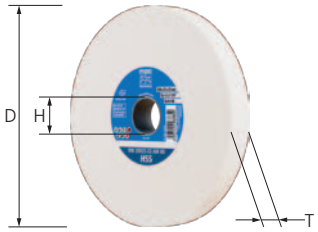
UNIVERSAL type

UNIVERSAL type bench grinding wheels are ideal for universal use in the workshop.

Materials that can be worked:
steel, cast steel, stainless steel (INOX), cast iron

Type:
Vitrified bond, regular aluminium oxide, hardness grade: Q (grit size 24), P (grit size 36), M (grit size 60), structural density: 5 (grit size 24 and 36), 6 (grit size 60)

D x T [mm]	H [mm]	Grit size			Reductions	Max. RPM		Description
		24	36	60				
		EAN 4007220						
Aluminium oxide, regular (AN)								
125 x 20	32	-	037904	037997	25/20/16	5,350	1	BW 12520-32 AN ... UNIVERSAL
150 x 16	32	610138	-	610145	25/20/16	4,500	1	BW 15016-32 AN ... UNIVERSAL
150 x 20	32	610176	037911	610183	25/20/16	4,500	1	BW 15020-32 AN ... UNIVERSAL
150 x 25	32	610213	-	610220	25/20/16	4,500	1	BW 15025-32 AN ... UNIVERSAL
175 x 25	32	-	037928	038000	25/20/16	3,750	1	BW 17525-32 AN ... UNIVERSAL
	51	-	037935	038017	32	3,750	1	BW 17525-51 AN ... UNIVERSAL
200 x 20	32	610305	-	610312	25/20/16	3,350	1	BW 20020-32 AN ... UNIVERSAL
200 x 25	32	610350	037942	610367	25/20/16	3,350	1	BW 20025-32 AN ... UNIVERSAL
	51	-	037959	038024	32	3,350	1	BW 20025-51 AN ... UNIVERSAL
200 x 30	32	612378	-	610398	25/20/16	3,350	1	BW 20030-32 AN ... UNIVERSAL
200 x 32	51	-	037966	038031	32	3,350	1	BW 20032-51 AN ... UNIVERSAL
250 x 32	51	-	037973	038048	32	2,700	1	BW 25032-51 AN ... UNIVERSAL
300 x 40	76	-	037980	038062	-	2,250	1	BW 30040-76 AN ... UNIVERSAL



HSS type

HSS type bench grinding wheels are particularly useful for sharpening HSS pilot drills or machining other high-alloy steels.

Materials that can be worked:
tool steels, case-hardened steels, hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC)

Type:
Vitrified bond, white aluminium oxide, hardness grade: K, structural density: 7

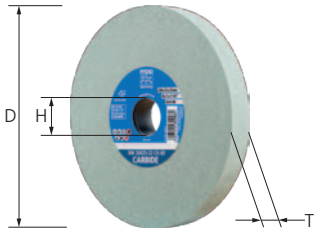
D x T [mm]	H [mm]	Grit size		Reductions	Max. RPM		Description
		60	80				
		EAN 4007220					
Aluminium oxide (AW)							
125 x 20	32	-	037812	25/20/16	5,350	1	BW 12520-32 AW ... HSS
150 x 16	32	610152	-	25/20/16	4,500	1	BW 15016-32 AW ... HSS
150 x 20	32	610190	037829	25/20/16	4,500	1	BW 15020-32 AW ... HSS
150 x 25	32	610237	-	25/20/16	4,500	1	BW 15025-32 AW ... HSS
175 x 25	32	-	037836	25/20/16	3,750	1	BW 17525-32 AW ... HSS
	51	-	037843	32	3,750	1	BW 17525-51 AW ... HSS
200 x 20	32	610329	-	25/20/16	3,350	1	BW 20020-32 AW ... HSS
200 x 25	32	610374	037850	25/20/16	3,350	1	BW 20025-32 AW ... HSS
	51	-	037867	32	3,350	1	BW 20025-51 AW ... HSS
200 x 30	32	612385	-	25/20/16	3,350	1	BW 20030-32 AW ... HSS
200 x 32	51	-	037874	32	3,350	1	BW 20032-51 AW ... HSS
250 x 32	51	-	037881	32	2,700	1	BW 25032-51 AW ... HSS
300 x 40	76	-	037898	-	2,250	1	BW 30040-76 AW ... HSS

CARBIDE type

CARBIDE type bench grinding wheels are used on hard materials, such as for sharpening tungsten carbide tools.

Materials that can be worked:
tungsten carbide, hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC), steel materials with a hardness > 54 HRC, glass

Type:
Vitrified bond, green silicon carbide, hardness grade: J, structural density: 7



D x T [mm]	H [mm]	Grit size 60	Grit size 80	Grit size 120	Reductions	Max. RPM		Description
		EAN 4007220						
Silicon carbide (CN)								
125 x 20	32	-	038079	-	25/20/16	5,350	1	BW 12520-32 CN ... CARBIDE
150 x 16	32	-	-	610169	25/20/16	4,500	1	BW 15016-32 CN ... CARBIDE
150 x 20	32	718902	038086	610206	25/20/16	4,500	1	BW 15020-32 CN ... CARBIDE
150 x 25	32	-	-	610244	25/20/16	4,500	1	BW 15025-32 CN ... CARBIDE
175 x 25	32	-	038093	-	25/20/16	3,750	1	BW 17525-32 CN ... CARBIDE
	51	-	038109	-	32	3,750	1	BW 17525-51 CN ... CARBIDE
200 x 20	32	-	610336	610343	25/20/16	3,350	1	BW 20020-32 CN ... CARBIDE
200 x 25	32	-	629031	610381	25/20/16	3,350	1	BW 20025-32 CN ... CARBIDE
	51	-	038116	-	32	3,350	1	BW 20025-51 CN ... CARBIDE
200 x 30	32	-	-	612392	25/20/16	3,350	1	BW 20030-32 CN ... CARBIDE
200 x 32	51	-	038123	-	32	3,350	1	BW 20032-51 CN ... CARBIDE
250 x 32	51	-	038130	-	32	2,700	1	BW 25032-51 CN ... CARBIDE
300 x 40	76	-	038147	-	-	2,250	1	BW 30040-76 CN ... CARBIDE

Grinding and polishing stones
General information

PFERD grinding and polishing stones are versatile tools for finish machining on forms in tool and mould-making. They are used for step-by-step fine grinding after machining or after electrical discharge machining (EDM) to grind in a brushed finish/polish in the demoulding direction or to prepare for high-gloss polishing with diamond pastes.

Advantages:

- Long tool life.
- High dimensional stability.
- High abrasive performance.
- Even stock removal.
- Fine surface finish.

Applications:

- Surface work
- Polishing
- Rounding
- Finishing
- Step-by-step fine grinding

Recommendations for use:

- A quick-mounting handle is recommended in manual applications to make work more ergonomic.
- The use of grinding oils is recommended to achieve a better surface finish.
- Sort the polishing stones by type to avoid grain being carried over.

Matching tool drives:

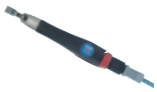
- Manual filing machine

Ordering notes:

- Please complete the description with the desired grit size.

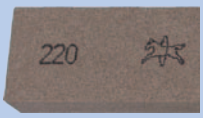
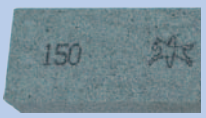
Detailed information on grinding oils can be found in catalogue section 4.

Detailed information on ceramic fibre files can be found in catalogue section 4.



A manual filing machine is recommended to make work easier. Detailed information can be found in catalogue section 9.

The fast way to the best tool

Material group ▼		Type ▶	UNIVERSAL 	CARBIDE 
Steel	Steels up to 1,200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, tempering steels	●	❍
	Hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC)	Tool steels, tempering steels, alloyed steels	❍	●
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	●	
Tungsten carbide	–	–		●
Non-ferrous metals	Soft non-ferrous metals, non-ferrous metals	Aluminium alloys, brass, copper, zinc	●	
	Hard non-ferrous metals	Bronze, titanium, titanium alloys, hard aluminium alloys	●	

● = highly suitable ❍ = suitable

UNIVERSAL type

The UNIVERSAL type grinding and polishing stones are the all-rounders for step-by-step fine grinding in tool and mould construction.

Materials that can be worked:
hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC), stainless steel (INOX), aluminium, other non-ferrous metals

Type:
Vitrified bond, regular aluminium oxide

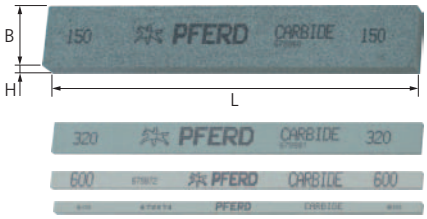
Width [mm]	Height [mm]	Length [mm]	Grit size 220	320	400	600		Description
			EAN 4007220					
Square								
4	4	150	106679	106969	107034	107096	12	SPS 4x4x150 AN ... UNIVERSAL
6	3	150	106914	106976	107041	107102	12	SPS 6x3x150 AN ... UNIVERSAL
	6	150	106921	106983	107058	107119	12	SPS 6x6x150 AN ... UNIVERSAL
13	3	150	106938	107003	107065	107126	12	SPS 13x3x150 AN ... UNIVERSAL
	6	150	106945	107010	107072	107133	12	SPS 13x6x150 AN ... UNIVERSAL
25	13	150	106952	107027	107089	107140	6	SPS 25x13x150 AN ... UNIVERSAL

CARBIDE type

The CARBIDE type soft grinding and polishing stones enable high removal rates without clogging on hard materials in tool and mould construction.

Materials that can be worked:
high-temperature-resistant materials, tungsten carbide, steel materials with a hardness > 54 HRC

Type:
Vitrified bond, green silicon carbide



Width [mm]	Height [mm]	Length [mm]	Grit size 150	220	320	400	600		Description
			EAN 4007220						
Square									
4	4	150	107157	107218	107270	107331	107393	12	SPS 4x4x150 CN ... CARBIDE
6	3	150	107164	107225	107287	107348	107409	12	SPS 6x3x150 CN ... CARBIDE
	6	150	107171	107232	107294	107355	107416	12	SPS 6x6x150 CN ... CARBIDE
13	3	150	107188	107249	107300	107362	107423	12	SPS 13x3x150 CN ... CARBIDE
	6	150	107195	107256	107317	107379	107430	12	SPS 13x6x150 CN ... CARBIDE
25	13	150	107201	107263	107324	107386	107447	6	SPS 25x13x150 CN ... CARBIDE

Arbors for grinding and polishing stones

SPSH 6x6/6x13:
Offers space to clamp two different cross sections.

SPSH 6x3/6x6/13x1,5/13x3:
Is used to clamp four different cross sections.

SPSH 3-13mm 3,1:
The arbor for the manual filing machine is variably adjustable.

SPSH 6x6/6x13
SPSH 6x3/6x6/13x1,5/13x3

SPSH 3-13mm 3,1

Matching cross sections	EAN 4007220		Description
Manual application			
6 x 6 mm, 13 x 6 mm	107553	1	SPSH 6x6/6x13
6 x 3 mm, 13 x 1.5 mm / 6 x 6 mm, 13 x 3 mm	107560	1	SPSH 6x3/6x6/13x1,5/13x3
Manual filing machine shank diameter of 3.17 x 20 mm [S_d x L_2]			
all grinding and polishing stones	107577	1	SPSH 3-13mm 3,1

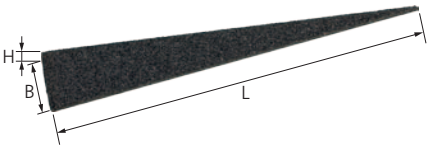
Dressing stones

Dressing stone SE 1203050 CU 30 R 5 V:
Dressing stone with coarse grain (grit size 30) for coarse dressing work. The rubber backing provides a slip-free grip and protects the support surfaces from damage.

Dressing stone SE 1203050 CU 30/60 R 5 V:
Dressing stone with two different grit sizes:
- Upper side (coarse): Profiling and dressing of large mounted points with coarse bonds and grain
- Underside (fine): Profiling and dressing of mounted points with fine bonds and grain

Dressing stone SE 702212 CU 46 M 5 V:
Small dressing stone with finer grain for profiling and dressing of smaller mounted points.

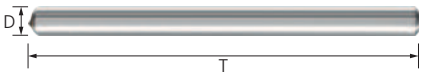
L x H x B [mm]	EAN 4007220		Description
120 x 30 x 50	103500	5	SE 1203050 CU 30 R 5 V
	505687	5	SE 1203050 CU 30/60 R 5 V
70 x 22 x 12	114445	5	SE 702212 CU 46 M 5 V



Abrasive segments

Wedge-shaped abrasive segments for work on sand moulds and cores in foundries.
Using the abrasive segments, the intersections and separators on sand moulds and cores can be re-finished and removed.
The wedge-shaped design allows effortless work in both very narrow areas and on large surfaces.

L x H x B [mm]	EAN 4007220		Description
235 x 42 x 4	800034	10	SE 235-42-4 AN 46 N 5 B
246 x 32 x 5	800041	10	SE 246-32-5 AN 46 N 5 B



Diamond dresser

Long-life diamond dresser with large single grit diamond for profiling and dressing mounted points, grinding discs and Poliflex grinding points (see catalogue section 4).
Using this diamond dresser, blunt grit and metal particles can be removed from the grinding tool, and the required grinding wheel shapes can be produced.

Recommendations for use:
- Protect the diamond dresser from impacts and impact-type loads.
- Clamp deeply and ensure it is well tightened.
- Insert at an angle of 5 to 15 degrees, just below the mounted point or disc centre.

L x D [mm]	EAN 4007220	Carats [ct]		Description
81 x 6	103494	0.20	1	400 B

If you cannot find the solution for your particular application in our extensive catalogue range, we can produce mounted points in premium PFERD quality specifically for your application on request. We can take into account your specifications and needs, drawings, information on bonds and hardness grades, grit sizes, grain types, shapes, dimensions, shanks and packaging.

Please speak to our sales representatives. We will be happy to advise you.

1. Process analysis and tool development

Contact us to arrange an appointment with our experienced sales representatives and technical customer support team. **You can find our worldwide sales addresses at www.pferd.com.**

Our employees will **analyse your application with you on-site** and develop the most economic individual tool solution for you! You will then receive a quote.

2. Production

Our production teams subsequently create a technical drawing with which your made-to-order product will be produced.

Each mounted point is supplied **in premium PFERD quality**. We always work to the highest standards, from the inspection of raw materials, through inspections during the course of production by our staff, up to the final visual inspection of each individual mounted point.

The quality of PFERD tools is certified according to ISO 9001.

3. Use

Our flexible production and global logistics network ensure that you receive your new tool on time.

If desired, your personal sales representative and a technical adviser will set up all the process parameters together with you.

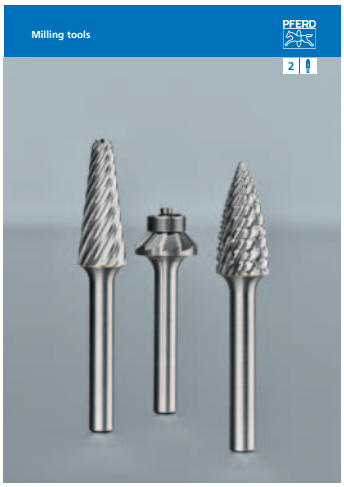
See the quality, performance and economic value of PFERD tools for yourself!

Examples of custom PFERD tools

Quality tools from a single source

Catalogue section 1

Files



Catalogue section 2

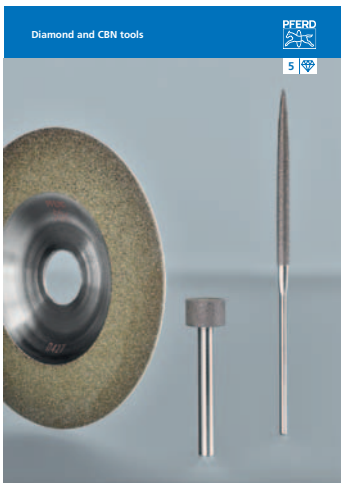
Milling tools

Catalogue section 3

Mounted points

Catalogue section 4

Fine grinding and polishing tools



Catalogue section 5

Diamond and CBN tools

Catalogue section 6

Cut-off wheels, flap discs and grinding wheels

Catalogue section 7

Cut-off wheels for stationary applications

Catalogue section 8

Industrial power brushes

Catalogue section 9

Tool drives